

LC-300V

For vertical downward welding of 50kgf/mm²
class high tensile strength steel

AWS A5.1 E7048
KS D 7006 E5016
JIS Z3211 E4948

Applications

Vertical downward welding of ships, buildings and bridges.

Characteristics

LC-300V is a low hydrogen type electrode for exclusively vertical downward welding. Mechanical properties and crack resistibility of weld metal are good and slag is self-lifting. As higher amperage can be used, the efficiency of vertical welding is remarkably improved compared with vertical upward welding.

Notes on usage

- (1) Manipulate the electrode straight downward without weaving and press its tip against the mother plate as shown in the sketch.
- (2) Dry the electrodes at 350~400°C for about 60 minutes before use.
- (3) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	1.03	0.55	0.011	0.009

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	IV J (kgf-m)
			-30°C
500(51)	580(57)	28	110(11)

Size & recommended current range (AC or DC +)

Dia. (mm)	3.2	4.0	4.5	5.0	5.5	6.0	
L (mm)	400	450	450	450	450	450	
Amp.	V-down	100-160	140-210	180-240	220-270	260-330	310-360

• Tip Color : Green