

LC-300Z

Low fume type for welding of 50kgf/mm² class high tensile strength steel

AWS A5.1 E7016
KS D 7006 E5016
JIS Z3211 E4916

Applications

Welding of 50kgf/mm² class high tensile strength steels in ships, bridges, buildings and pressure vessels.

Characteristics

LC-300Z is low hydrogen type electrode whose fume generation is 20~30% lower than conventional low hydrogen type electrodes for all-position welding of 50kgf/mm² class high tensile strength steels.

X-ray soundness and mechanical properties of the weld metal are excellent. The usabilitys such as arc smoothness, slag removal and bead appearance are good.

Notes on usage

- (1) Dry the electrodes at 350~400°C for about one hour before use.
- (2) Adopt the backstep method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.
- (3) Keep the arc as short as possible.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.07	0.95	0.52	0.013	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
480(49)	560(57)	31	130(13)

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0	
	L (mm)	350	350	400	400(450)	450
Amp.	F	55-85	90-130	130-180	180-240	250-310
	V&OH	50-80	80-115	110-170	150-200	-

• Tip Color : Black