

LC-318HR

For mild steel and 490N/mm² class high tensile strength steel Extra Low Hydrogen

AWS A5.1 E7016 H4R
KS D 7006 E5016
JIS Z 3211 E4916 H5

Applications

Welding of 490N/mm²(50kgf/mm²) class high tensile strength steels ships, bridges, buildings and pressure vessels.

Characteristics

- 1) LC-300HR is the most widely used extra low hydrogen type covered electrode for all position welding of 50kgf/mm² class high tensile strength steels.
- (2) X-ray soundness and mechanical properties of the weld metal are excellent.
- (3) The usability such as arc smoothness, slag removal and bead appearance are good.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Adopt the back-step 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	1.02	0.52	0.012	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
512(52)	594(60)	30.0	130(13)

Size & recommended current range (DC +)

Dia.mm(in)	2.6	3.2	4.0	5.0	
	L (mm)	350	350	400	400(450)
Amp.	F	55-85	90-130	130-180	180-240
	V&OH	50-80	80-115	110-170	150-220

• Tip Color : Yellow