

LC-328

For highly efficient welding of 50kgf/mm²
class high tensile strength steel

AWS A5.1 E7028
KS D 7006 E5026
JIS Z3211 E4928

Applications

Flat and horizontal fillet welding of 50kgf/mm² class high tensile strength steel for structures, large size steel castings and strength members of ship hulls.

Characteristics

LC-328 is an iron powder low hydrogen type electrode for exclusive use in flat and horizontal fillet welding.

Its deposition rate is extremely high, and its slag removal is also good. Therefore, operation time is shortened and it is very efficient. Its paint resistibility is excellent.

It is applicable for multi-layer fillet welding as well as single layer fillet welding.

Notes on usage

- (1) Dry the electrodes at 250~300°C for 30~60 minutes before use.
- (2) Adopt 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.
- (4) Optimum bead length/burned up electrode length ratio for gravity welding is 1.2~1.5.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.07	1.06	0.73	0.012	0.010

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)
			-20°C
510(52)	580(59)	30	100(10)

Size & recommended current range (AC or DC +)

Dia. (mm)		4.0	4.5	5.0	5.5	6.0	6.4	7.0
L (mm)		400, 450	550, 700	550, 700	550, 700	550, 700	550, 700	550, 700
Amp.	F&H-F	160-200	180-230	200-250	230-290	270-330	290-360	320-400

• Approval : KR

• Tip Color : White