

LC-400G

For welding of 55kgf/mm² class
high tensile strength steel

AWS A5.5 E8016-G
KS D 7006 E5316
JIS Z3211 E5516-G

Applications

Welding of 55kgf/mm² class high tensile strength steel in ships, buildings, bridges and pressure vessels.

Characteristics

LC-400G is a low hydrogen type electrode for all-position welding, which provides good strength property of weld metal even after post weld heat treatment.

The usability, X-ray soundness and mechanical properties of weld metal are excellent.

Notes on usage

- (1) Dry the electrodes at 350~400°C for about one hour 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.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Mo
0.07	1.28	0.50	0.010	0.007	0.30

Typical mechanical properties of weld metal (PWHT: 620°C×40hr)

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	IV J (kgf-m)
			-20°C
540(55)	630(64)	28	140(14)

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(500)	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