

LC-400

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

AWS A5.1 E7018
KS D 7006 E5316
JIS Z3211 E4916

Applications

Welding of 55kgf/mm² class high tensile strength steel for pressure vessels and bridge constructions.

Characteristics

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

X-ray soundness and mechanical properties of weld metal are excellent. As the hydrogen content of the weld metal is especially low, its crack resistibility is good.

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	0.92	0.48	0.015	0.008	0.13

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
540(55)	630(64)	29	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 : Red