

LCA-300

For corrosion-resistant steel at hydrochloric & sulfuric acid environmental conditions such as thermal power plant, bridges and storage tanks etc.

AWS A5.1 E7016-G

Applications

Butt, fillet welding of corrosion-resistant steel at hydrochloric & sulfuric acid environmental conditions such as thermal power plant, bridges and storage tanks etc.

Characteristics

- (1) LCA-300 is a low hydrogen type electrode for all-position welding of 50kgf/mm² class high tensile strength weather proof steels.
- (2) It provides the excellent usability stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.

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	Cu	Ni
0.055	0.65	0.47	0.011	0.009	0.30	0.20

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)
	Room Temp.	500°C		0°C
512(52)	585(60)	464(47)	30.0	146(14.8)

Size & recommended current range (DC +)

Dia.mm(in)		2.6	3.0	4.0	5.0
L (mm)		350	350	400	400
Amp.	F	55-85	90-130	130-180	180-240
	V&OH	50-80	80-115	110-170	150-220

• Tip Color : Orange