

# LCW-300

For welding of 50kgf/mm<sup>2</sup> class high tensile strength weather proof steel

AWS A5.5 E7016-G  
KS D 7101 DA5016G  
JIS Z3214 DA5016G

## Applications

Welding of mild steel and 50kgf/mm<sup>2</sup> class high tensile strength weather proof steels for buildings, bridges and cars.

## Characteristics

LCW-300 is a low hydrogen type electrode for all-position welding of 50kgf/mm<sup>2</sup> class high tensile strength weather proof steels.

It is suitable for welding of relatively thick plate.

## Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Adopt the 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	Cu	Ni	Cr
0.07	0.65	0.46	0.012	0.008	0.35	0.30	0.25

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)
			-20°C
510(52)	570(58)	31	180(18)

## 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	80-130	130-180	180-240	250-310
	V&OH	50-80	80-115	110-170	150-200	-

• Tip Color : Orange