

LCW-318

For welding of 50kgf/mm² class high tensile strength weather proof steel

AWS A5.5 E7018-W1
KS D 7101 DA5026G
JIS Z3214 DA5026G

Applications

Welding of 50kgf/mm² class high tensile strength weather proof steel of structures, building, vehicles and bridges.

Characteristics

LCW-318 is an all position iron powder low hydrogen type electrode which exhibits high crack resistibility and superior notch toughness of depositing weld metal. It is suitable for welding comparatively thick plates of weather proof steel.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Adopt 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	Cr
0.06	0.58	0.54	0.016	0.006	0.43	0.28	0.23

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
520(53)	580(59)	29	180(18)

Size & recommended current range (AC or DC +)

Dia. (mm)	3.2	4.0	5.0	6.0	
	L (mm)	350	400	400(450)	450
Amp.	F	90-130	130-190	200-240	250-300
	V&OH	70-110	100-170	160-210	-

• Tip Color : White