

LCW-418

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

AWS A5.5 E8018-W2
KS D 7101 DA5826W
JIS Z3214 DA5826W

Applications

Welding of 55kgf/mm² class high tensile strength weather proof steels for bridges, structures and rolling stock.

Characteristics

LCW-418 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. The mechanical properties of the weld metal is good.

Notes on usage

- (1) Dry the electrodes at 350~400°C for about one hour 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	0.8	0.50	0.017	0.007	0.39	0.54	0.55

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)	620(63)	27	130(13)

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 : Silver