

LCW-500

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

AWS A5.5 E7028
KS D 7101 DA5000W
JIS Z3214 DA5000W

Applications

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

Characteristics

LCW-500 is an special type electrode for exclusive use in flat and horizontal fillet welding.

Its deposition rate is extremely high.

Notes on usage

- (1) Dry the electrodes at 250~300°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	Cu	Ni	Cr
0.06	0.88	0.24	0.012	0.008	0.48	0.24	0.50

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)
			0°C
480(49)	560(57)	30	90(9)

Size & recommended current range (AC or DC +)

Dia. (mm)	4.0	5.0	5.5	6.0	6.4
L (mm)	400	550(700)	700	700	700
Amp.	F&H-F	180~240	200~250	230~290	270~330

• Tip Color : White