

LH-100V

For vertical downward welding

AWS A5.1 E7048
KS D 7004 E4316
JIS Z3211 E4316

Applications

Vertical downward welding of ships, buildings, bridges, vehicles and machines.

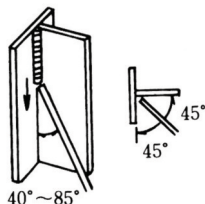
Characteristics

LH-100V is a low hydrogen type electrode specifically designed for exclusive use in vertical downward welding and to obtain high welding efficiency in vertical welding.

Deposited metal shows high crack resistance and excellent mechanical properties.

Notes on usage

- (1) Manipulate the electrode straight downward without weaving, contacting its tip onto a mother plate as shown in the sketch.
- (2) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (3) Keep the arc as short as possible.
- (4) 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.



Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.92	0.55	0.012	0.010

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)
			-30°C
450(46)	560(57)	32	100(10)

Size & recommended current range (AC or DC +)

Dia. (mm)	3.2	4.0	4.5	5.0	5.5	
L (mm)	400	450	450	450	450	
Amp.	V-down	100-160	140-210	180-240	220-270	260-330

• Tip Color : Black