

LH-100

For welding of heavy-duty structures
and heavy plates

AWS A5.1 E7016
KS D 7004 E4316
JIS Z3211 E4316

Applications

Welding of general heavy structural steels for ships, bridges, machines and pressure vessels made of mild steel.

Characteristics

LH-100 is a low hydrogen type electrode with excellent crack resistance, mechanical properties and X-ray soundness. The Welding in all position can be easily done with the good usabilities of stable arc, slag removal and bead appearance.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Take the backstep method or strike the arc on a small steel plate prepared 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
0.08	0.96	0.45	0.012	0.009

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
470(48)	550(56)	33	130(13)

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	6.0	
	L (mm)	300	350	350	400	400,450	450
Amp.	F	35-60	55-85	90-130	135-185	190-250	250-320
	V&OH	30-55	50-80	80-120	110-160	165-210	-

• Tip Color : White