

LH-28W

For one side welding

AWS A5.1 E7016
KS D7004 E4316
JIS Z3211 E4316

Applications

One side welding of pipes and general butt joints of mild steel and 50kgf/mm² class high tensile strength steel.

Characteristics

LH-28W is a low hydrogen type electrode for exclusive use for one side welding of pipes and general structures.

Its arc stability is extremely good to perform one side welding with relatively low currents.

LH-28W provides good slag detachability and smooth weld beads.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Strike the arc on a small steel plate prepared for this purpose or on the side wall of the groove.
- (3) Keep the arc as short as possible.
- (4) Reverse welds of good appearance is obtained with proper currents and optimum root gaps (about 3mm).
- (5) Stop the arc after moving the crater to the side wall to the groove.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.86	0.64	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)-20°C
470(48)	560(57)	31	90(9)

Size & recommended current range (AC or DC ±)

Dia. (mm)		2.6	3.2	4.0	5.0
L (mm)		350	400	400	400
Amp.	F	60-90	90-130	125-180	180-240
	V&OH	50-80	80-115	110-170	150-210
	One side welding	30-65	60-110	90-140	130-180

• Tip Color : Green