

LPA-118

For welding of low temperature services and
1%Ni steel

AWS A5.5 E8018-C3

Applications

Welding of 1%Ni steel used low temperature services of 55kgf/mm² class high tensile strength steel such as ASTM A588 and A242 steels.

Characteristics

LPA-118 is an iron powder low hydrogen type electrode for all-position welding. Notch toughness at low temperature (-40°C) is excellent, because it contains more Ni compared with other electrodes.

Notes on usage

- (1) Dry the electrodes at 350~400°C for about one hour before use.
- (2) Keep the arc as short as possible.
- (3) Adopt backstep method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.
- (4) Preheat at 50~100°C depending on the kind of steel and its thickness.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni
0.07	0.89	0.37	0.010	0.004	1.00

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)
			-40°C
530(54)	600(61)	30	130(13)

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	5.5	
	L (mm)	350	350	400 450	400 450	450
Amp.	F	60-100	90-130	130-190	200-240	230-270
	V&OH	50-80	70-130	100-170	160-210	-

• Approval : ABS

• Tip Color : Black