

LT-25

For welding of general mild steel

KS D 7004 E4303
JIS Z3211 E4303

Applications

Welding of shipbuilding, vehicles, bridges, buildings and other general structures.

Characteristics

LT-25 is a lime titania type electrode, whose usability is excellent in all position welding. It deposits smooth and flat bead with easy manipulation particularly in vertical and overhead positions.

Mechanical properties of weld metal are excellent next to that of low hydrogen type electrodes.

Notes on usage

- (1) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lowers X-ray soundness, but also causes increase of spatter, undercut and insufficient slag covering.
- (2) Dry the electrodes at 70~100°C for 30~60 minutes before use. Excessive moisture absorption lowers usability and may result in some porosities.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.07	0.37	0.15	0.014	0.012

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
420(43)	480(49)	32	100(10)

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.6	3.2	4.0	4.5	5.0	6.0	
	L (mm)	350	350	400	400	400	450
Amp.	F	65-100	100-140	140-190	170-230	200-260	250-330
	V&OH	50-90	80-130	110-170	125-190	140-210	-

• Tip Color : Orange