

# LTI-25

For highly efficient welding in all positions

KS D 7004 E4303  
JIS Z3211 E4303

## Applications

Welding of ship hulls, vehicles, machinery, buildings and bridges.

## Characteristics

LTI-25 is an iron powder lime titania type electrode which provides highly efficient welding by high deposition rate and good re-arcing property. This is characterized by exceptionally welding speed increase, easy slag removal even from narrow grooves and outstanding bead appearance.

## Notes on usage

- (1) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lower 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
0.08	0.36	0.15	0.013	0.013

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)
			0°C
410(42)	450(46)	32	120(12)

## 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	50-100	90-130	140-180	160-210	190-250	250-330
	V&OH	50-90	80-130	110-170	125-190	140-210	-

• Approval : NK

• Tip Color : White