LB-26 FAMILIARC™

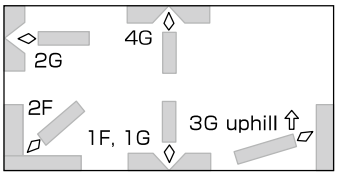
Stick electrode

Features: ▪ Low hydrogen type containing iron powder

Classification: AWS A5.1 E7016

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Blue white
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	20	170W, 110H, 380L
3.2	350	5	20	34	170W, 115H, 380L
4.0	400	5	20	60	170W, 110H, 430L
5.0	450	5	20	106	170W, 110H, 480L
6.0	450	5	20	150	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.15
Si	0.50	0.75
Mn	1.01	1.60
P	0.013	0.035
S	0.003	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	0.01	0.08
Others [b]	1.05	1.75

Note: [a] Single values are maximum.
[b] Combined Limit for Mn+Ni+Cr+Mo+V

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	100~140	90~130
4.0	140~190	120~180
5.0	190~250	160~210
6.0	260~320	-

All-weld mechanical properties

	Typical (AC)		Guaranty	
0.2%YS (MPa)	480	410	400min.	340min.
TS (MPa)	550	500	483min.	450min.
El on 4d (%)	33	34	22min.	25min.
IV -29℃ (J)	100	130	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1

Approvals

ABS	3, H15
LR	3Ym, H15
DNV	3Y, H10
BV	3, 3Y, H15
NK [a)]	KMW3, H15
CR	3, 3Y, H15

Note: [a)] AC