LB-52T FAMILIARC™

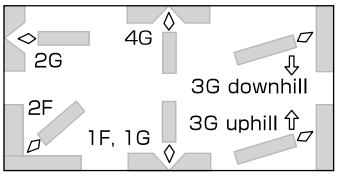
Stick electrode

Features: ▪ Low hydrogen type for tack welding

Classification: AWS A5.1 E7048

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	36	170W, 115H, 380L
4.0	400	5	20	60	170W, 105H, 430L
5.0	450	5	20	96	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.15
Si	0.47	0.90
Mn	1.04	1.60
P	0.012	0.035
S	0.002	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	<0.01	0.08
Others [b]	1.07	1.75

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

Welding parameters (A)

ϕ mm	All position (1F, 1G, 2F, 2G, 3G uphill, 4G) & 3G downhill
3.2	110~160
4.0	160~220
5.0	200~260

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	450	400min.
TS (MPa)	540	483min.
El on 4d (%)	32	22min.
IV -29℃ (J)	110	27min.
PWHT	AW	AW

Approvals

ABS	3, 3Y, 3Y400, H10
LR	3Ym, H15
DNV	3Y, H10
BV	3, 3Y, H10
NK	KMW53Y40, H10
CR [a)]	3, 3Y, H10

Note: [a)] AC