LB-52U FAMILIARC™

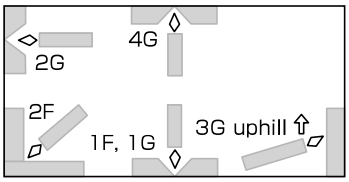
Stick electrode

Features:
- Suitable for one side welding of pipes
- Extremely good arc stability in one side welding with relatively low current

Classification: AWS A5.1 E7016

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Blue white, 2nd Pink
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	400	5	20	35	170W, 110H, 430L
4.0	400	5	20	53	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.15
Si	0.64	0.75
Mn	0.86	1.60
P	0.012	0.035
S	0.008	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	0.01	0.08
Others [b]	0.90	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	Root pass [c]
2.6	60~90	50~80	30~80
3.2	90~130	80~120	60~110
4.0	130~180	110~170	90~140

Note: [c] DCEN is also suitable.

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	480	400min.
TS (MPa)	560	483min.
El on 4d (%)	31	22min.
IV -29℃ (J)	80	27min.

Approvals

ABS	3Y, MG, H10
LR	3Ym, MG, H15
DNV	3Y, H10
BV	3YH10
NK [a)]	KMW53, H10
CCS	3Y, H10
NAKS	AWS A5.1 E7016

Note: [a)] AC