LB-55U FAMILIARC™

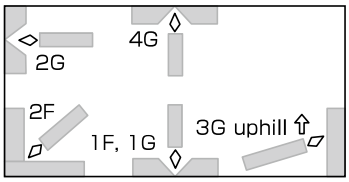
Stick electrode

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

Classification: AWS A5.5 E8016-G

Redrying Conditions: 350~400℃x1h
Identification color: -
Polarity: AC, DCEP, DCEN (Root Pass only)

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 (DCEP)	Guaranty [a]
C	0.06	0.15
Si	0.49	0.75
Mn	1.70	1.40~2.25
P	0.015	0.030
S	0.005	0.030

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G	Root pass [b]
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: [b] DCEN is also suitable.

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	570	462min.
TS (MPa)	620	552min.
El on 4d (%)	31	19min.
IV -40℃ (J)	110	32min.

Approvals

ABS	3YQ460 H10, MG
LR	3Y46m, H10
DNV	3Y46 H10, MG
BV	3Y46H10 UP