LB-57 FAMILIARC™

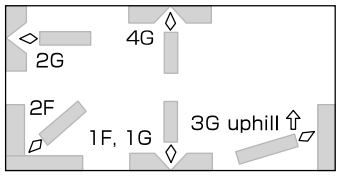
Stick electrode

Features: ▪ Suitable for butt and fillet welding of 520MPa high tensile steel

Classification: AWS A5.1 E7016

Redrying Conditions: 350~400℃x1h
Identification color: 1st Blue, 2nd Brown
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, 125H, 380L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	450	5	20	97	170W, 105H, 480L
6.0	450	5	20	138	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.15
Si	0.64	0.75
Mn	0.81	1.60
P	0.011	0.035
S	0.003	0.035
Ni	0.01	0.30
Cr	0.03	0.20
Mo	0.17	0.30
V	0.01	0.08
Others [b]	1.03	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	50~85	50~80
3.2	90~130	80~115
4.0	130~180	110~170
5.0	180~250	150~200
6.0	250~310	-

All-weld mechanical properties

	Typical (AC)		Guaranty	
0.2%YS (MPa)	530	470	400min.	400min.
TS (MPa)	610	540	483min.	500min.
El on 4d (%)	31	32	22min.	25min.
IV -29℃ (J)	100	130	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x10