LB-70L TRUSTARC™

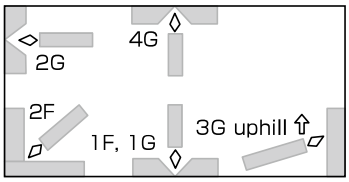
Stick electrode

Features:
- Suitable for butt and fillet welding
- Good impact values down to -60℃
- Excellent crack resistibility

Classification: AWS A5.5 E10016-G

Redrying Conditions: 350~430℃x1h
Identification color: 1st Green, 2nd Yellowish green
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.04	0.07
Si	0.40	0.20~0.60
Mn	1.18	0.80~1.40
P	0.01	0.03
S	<0.01	0.03
Ni	3.71	3.05~3.90
Cr	0.22	0.10~0.40
Mo	0.40	0.30~0.60

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	80~120	70~110
4.0	120~170	90~160

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	685	600min.
TS (MPa)	755	690min.
El on 4d (%)	27	16min.
IV -60℃ (J)	110	27min.

Approvals

ABS	4YQ620 H5
DNV	4Y62 H5

Note: DCEP