LB-78VS FAMILIARC™

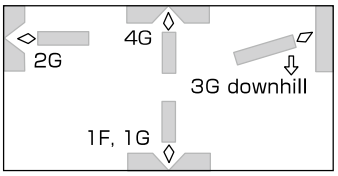
Stick electrode

Features:
- Suitable for butt welding of pipes
- Excellent usability in vertical downward welding
- Good mechanical properties

Classification: AWS A5.1 E7048

Redrying Conditions: 350~400℃x1h
Identification color: 1st Orange, 2nd Black
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	33	170W, 110H, 380L
4.0	400	5	20	56	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.15
Si	0.56	0.90
Mn	1.18	1.60
P	0.012	0.035
S	0.005	0.035
Ni	0.01	0.30
Cr	0.03	0.20
Mo	0.01	0.30
V	<0.01	0.08
Others [b]	1.23	1.75

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

Welding parameters (A)

ϕ mm	1F, 1G, 2G	3G uphill, 4G	3G downhill
3.2	80~140	80~120	80~140
4.0	130~210	110~160	130~210

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	490	400min.
TS (MPa)	580	483min.
El on 4d (%)	30	22min.
IV -29℃ (J)	100	27min.