LB-80L TRUSTARC™

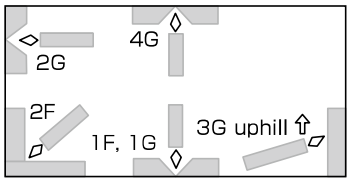
Stick electrode

Features:
- Good impact values down to -60℃
- Excellent crack resistibility

Classification: AWS A5.5 E11018-G H4

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 90H, 330L
3.2	350	5	20	32	170W, 120H, 380L
4.0	400	5	20	57	170W, 110H, 430L
5.0	400	5	20	90	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.04	0.09
Si	0.60	0.20~0.75
Mn	1.49	1.20~1.90
P	0.01	0.03
S	<0.01	0.03
Ni	2.92	2.50~3.30
Mo	0.77	0.40~1.00

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	65~95
3.2	80~120	70~110
4.0	120~160	90~150
5.0	170~210	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	770	669min.
TS (MPa)	830	759min.
El on 4d (%)	24	15min.
IV -60℃ (J)	100	47min.

Approvals

ABS	5YQ690 H5
LR	5Y69m H5
DNV	5Y69 H5
BV	5Y69 H5
CCS	5Y69 H5

Note: DCEP only