LB-80UL TRUSTARC™

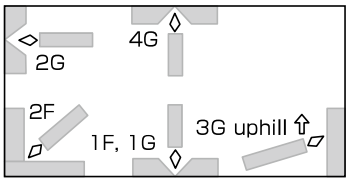
Stick electrode

Features:
- Suitable for 780MPa tensile strength steel
- Ultra low hydrogen type

Classification: AWS A5.5 E11016-G

Redrying Conditions: 350~430℃x1h
Identification color: 1st Brown, 2nd Green
Polarity: AC

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, 115H, 430L
5.0	400	5	20	87	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.07	0.09
Si	0.59	0.35~0.70
Mn	1.50	1.30~1.80
P	0.01	0.03
S	<0.01	0.03
Ni	1.90	1.70~2.10
Cr	0.22	0.10~0.40
Mo	0.45	0.25~0.55

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~115
4.0	130~180	110~170
5.0	180~240	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	710	669min.
TS (MPa)	820	759min.
El on 4d (%)	25	15min.
IV -20℃ (J)	110	27min.

Approvals

NK [a)]	KMW3Y69 H5
CCS	3Y69 H5

Note: [a)] AC