LB-88LT TRUSTARC™

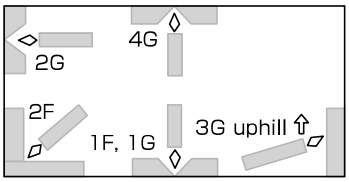
Stick electrode

Features:
- Good impact values down to -80℃
- Excellent crack resistibility

Classification: AWS A5.5 E11016-G

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	54	170W, 110H, 430L
5.0	400	5	20	87	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.04	0.09
Si	0.70	0.40~0.75
Mn	1.75	1.40~2.00
P	0.01	0.03
S	<0.01	0.03
Ni	2.62	2.10~2.80
Mo	0.73	0.50~0.80

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	100~170
5.0	180~240	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	750	669min.
TS (MPa)	840	759min.
El on 4d (%)	20	15min.
IV -80℃ (J)	63	27min.

Approvals

ABS	5YQ690 H5
DNV	5Y69 H5

Note: AC only