LB-98VS FAMILIARC™

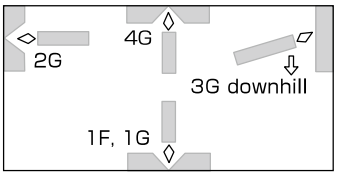
Stick electrode

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

Classification: AWS A5.5 E9018-G

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 110H, 380L
4.0	400	5	20	56	170W, 110H, 430L
4.5	400	5	20	67	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.05~0.10
Si	0.61	0.30~0.75
Mn	1.27	1.00~1.50
P	0.01	0.03
S	<0.01	0.03
Ni	1.17	0.90~1.40
Mo	0.18	0.40

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2G	4G	3G downhill
3.2	80~140	80~120	80~140
4.0	130~200	110~160	130~200
4.5	160~250	130~190	160~250

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	560	531min.
TS (MPa)	660	621min.
El on 4d (%)	30	17min.
IV -18℃ (J)	130	-