LB-116 TRUSTARC™

Stick electrode

Features: ▪ Suitable for 780MPa tensile strength steel

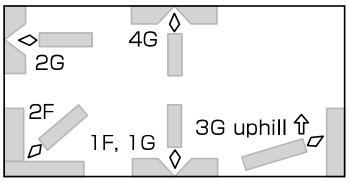
Classification: AWS A5.5 E11016-G

Redrying Conditions: 350~400℃x1h

Identification color: 1st Blue white, 2nd Red

Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 90H, 330L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	54	170W, 110H, 430L
5.0	400	5	20	86	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.07	0.09
Si	0.70	0.40~0.80
Mn	1.41	1.20~1.70
P	0.01	0.03
S	<0.01	0.03
Ni	1.89	1.50~2.10
Cr	0.28	0.20~0.40
Mo	0.46	0.35~0.55

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
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)	730	669min.
TS (MPa)	830	758min.
El on 4d (%)	24	15min.
IV -20℃ (J)	110	27min.