LB-8018 FAMILIARC™

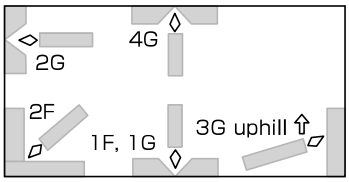
Stick electrode

Features:
- Suitable for butt and fillet welding of heavy structure
- Good performance by DCEP current

Classification: AWS A5.5 E8018-G

Redrying Conditions: 350~400℃x1h
Identification color: -
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	24	170W, 105H, 380L
3.2	400	5	20	41	170W, 105H, 430L
4.0	450	5	20	69	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty [a]
C	0.07	0.15
Si	0.34	0.75
Mn	1.74	1.40~2.25
P	0.012	0.030
S	0.007	0.030

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	65~95	60~90
3.2	90~130	80~120
4.0	130~190	110~170

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	540	462min.
TS (MPa)	615	552min.
El on 4d (%)	30	19min.
IV -40℃ (J)	150	32min.

Approvals

ABS	3YQ460 H10, MG
LR	3Y46m, H10
DNV	3Y46 H10, MG
BV	3Y46H10 UP