LB-W52 FAMILIARC™

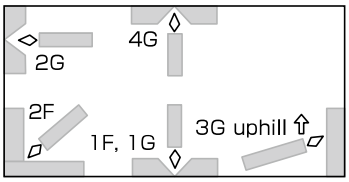
Stick electrode

Features: ▪ Suitable for weather proof steel

Classification: AWS A5.5 E7016-G

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Blue, 2nd Pink
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	30	170W, 110H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	450	5	20	95	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.12
Si	0.53	0.90
Mn	0.86	0.30~1.40
P	0.01	0.03
S	<0.01	0.03
Ni	0.30	0.25~0.70
Cr	0.04	0.30
Cu	0.33	0.20~0.60

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	80~130	80~115
4.0	130~180	110~170
5.0	180~240	150~210

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	490	393min.
TS (MPa)	550	483min.
El on 4d (%)	31	22min.
IV -29℃ (J)	130	-