LT-B50 TRUSTARC™

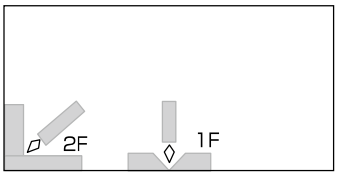
Stick electrode

Features:
- Suitable for flat and horizontal fillet welding
- Lime titania type

Classification: AWS -

Redrying Conditions: 70~100℃x0.5~1h
Identification color: 1st Purple, 2nd Orange
Polarity: AC, DCEP, DCEN

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
4.0	450	5	20	76	170W, 90H, 480L
4.5	550, 700	5	20	138, 175	170W, 60~75H, 580~730L
5.0	450, 550, 700	5, 10	20	130, 159, 203	170W, 60~95H, 480~730L
5.5	450, 550, 700	5, 10	20	153, 187, 239	170W, 65~95H, 480~730L
6.0	450, 550, 700	5, 10	20	176, 215, 273	170W, 65~95H, 480~730L
6.4	450, 550, 700	5, 10	20	189, 231, 294	170W, 60~95H, 480~730L
7.0	700	10	20	350	170W, 60H, 730L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.13
Si	0.39	0.10~0.70
Mn	0.94	0.60~1.25
P	0.017	0.030
S	0.009	0.025
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	0.01	0.08

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 2F
4.0	135~195
4.5	170~220
5.0	200~240
5.5	230~280
6.0	260~310
6.4	280~330
7.0	300~350

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	480	390min.
TS (MPa)	530	490min.
El on 4d (%)	29	16min.
IV 0℃ (J)	74	47min.

Approvals

ABS	3, 3Y
LR	3Ym, 3YG
DNV	3Y, MG
BV	3Y
NK	KMW53
CR	3Y