LT-B52A FAMILIARC™

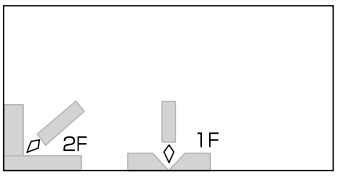
Stick electrode

Features:
- Suitable for flat and horizontal fillet welding
- Iron powder low hydrogen type

Classification: AWS A5.1 E7018

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
6.0	550	5	20	210	170W, 75H, 580L
6.4	700	10	20	295	170W, 65H, 730L
8.0	450, 550, 700	5, 10	20	268, 327, 416	170W, 80~115H, 480~730L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.11	0.15
Si	0.40	0.75
Mn	1.12	1.60
P	0.014	0.035
S	0.004	0.035
Ni	0.02	0.30
Cr	0.03	0.20
Mo	<0.01	0.30
V	0.01	0.08
Others [b]	1.18	1.75

Note: [a] Single values are maximum.
[b] Combined Limit for Mn+Ni+Cr+Mo+V

Welding parameters (A)

ϕ mm	1F, 2F
6.0	250~300
6.4	270~320
8.0	350~400

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	480	400min.
TS (MPa)	550	483min.
El on 4d (%)	30	22min.
IV -29℃ (J)	74	27min.

Approvals

ABS	3, 3Y, H10
LR	3Ym, 3YG, H15
DNV	3Y, H15
BV	3, 3Y, H10
NK [a)]	KMW53, H10

Note: [a)] AC