LB-52-18

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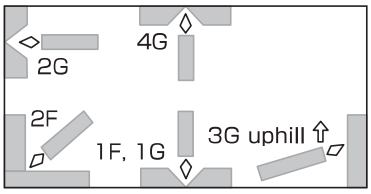
Stick electrode

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

Classification: AWS A5.1 E7018
EN ISO 2560-A-E 42 3 B

Redrying Conditions: 300~350℃x0.5~1h
Identification color: 1st Blue white, 2nd Blue
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
5.0	450	5	20	106	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.15
Si	0.59	0.75
Mn	0.97	1.60
P	0.013	0.035
S	0.007	0.035
Ni	0.02	0.30
Cr	0.03	0.20
Mo	<0.01	0.30
V	0.01	0.08
Others [b]	1.03	1.75

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

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
5.0	190~250	165~210

All-weld mechanical properties

	Typical (AC)		Guaranty	
0.2%YS (MPa)	500	420	400min.	350min.
TS (MPa)	560	520	483min.	460min.
El on 4d (%)	31	32	22min.	25min.
IV -29℃ (J)	110	140	27min.	27min.
PWHT (℃xh)	AW	620x1	AW	620±15x1

Approvals

ABS	3Y H10
LR	3Ym H15
DNV	3YH10
NK	KMW53H10