LC-318

For high efficient welding of 50kgf/mm^2 class high tensile strength steel

AWS	A5.1	E7018
KS	D7006	E5016
JIS	Z3211	E4916

Applications

Welding of 50kgf/mm^2 class high tensile strength steel of ships, bridges and pressure vessels.

Characteristics

LC-318 is iron powder low hydrogen type electrode for all-position welding. Its usability is the best with direct current application as well as alternating current application.

Notes on usage

(1) Dry the electrodes at 300~350℃ for 30~60 minutes before use.
(2) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.
(3) Keep the arc as short as possible.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.07	0.96	0.61	0.013	0.007

Typical mechanical properties of weld metal

YP N/mm^2(kgf/mm^2)	TS N/mm^2(kgf/mm^2)	EL %	IV J (kgf-m)-30℃
470(48)	560(57)	32	130(13)

Size & recommended current range (AC or DC +)

Dia. (mm)		2.6	3.2	4.0	5.0	5.5	6.0
L (mm)		350	350	400 450	400 450	450	450
Amp.	F	60-100	90-130	130-190	200-240	230-270	250-300
	V&OH	50-80	70-130	100-170	160-210	-	-

• Approval : ABS, BV, DNV, LR, NK
• Tip Color : Pink