

LH-100

For welding of heavy-duty structures
and heavy plates

AWS A5.1 E7016
KS D7004 E4316
JIS Z3211 E4316

Applications

Welding of general heavy structural steels for ships, bridges, machines and pressure vessels made of mild steel.

Characteristics

LH-100 is a low hydrogen type electrode with excellent crack resistance, mechanical properties and X-ray soundness. The Welding in all position can be easily done with the good usabilities of stable arc, slag removal and bead appearance.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Take the backstep method or strike the arc on a small steel plate prepared 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
0.08	0.96	0.45	0.012	0.009

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)-20°C
470(48)	550(56)	33	160(16)

Size & recommended current range (AC or DC ±)

Dia. (mm)	2.0	2.6	3.2	4.0	5.0	6.0	
L (mm)	300	350	350	400	400,450	450	
Amp.	F	35-60	55-85	90-130	135-185	190-250	250-320
	V&OH	30-55	50-80	80-120	110-160	165-210	-

• Tip Color : White