



LB-52U

FAMILIARC™

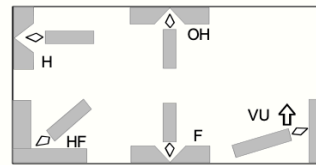
Low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

Classification: ASME / AWS A5.1 E7016
EN ISO 2560-A-E 42 2 B
JIS Z3211 D4316

Features : •Suitable for one side welding of pipes
•Extremely good arc stability in one side welding with relatively low current

Redrying Conditions: 300~350°Cx0.5~1 h

Welding Positions



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.08	0.64	0.86	0.012	0.008
Guaranty	0.05~0.10	≤0.75	≤1.60	≤0.020	≤0.020

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	480	560	31	-29°C: 80
Guaranty	≥400	≥480	≥22	-29°C ≥27

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	60~90A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	110~170A	150~200A
Root pass	30~80A	60~110A	90~140A	130~180A

Root pass: DC-EN is also suitable.

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB	LR	NV	BV	NK	Others
3H10,3Y	3m,3Ym(H15)	3YH10	3,3YHH	KMW3H10	CCS

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	20
3.2	400	5	20	25
4.0	400	5	20	53
5.0	400	5	20	82