Shielded Metal Arc Welding

LB-62U

TRUSTARC™

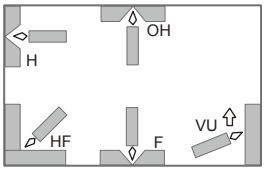
Extra low hydrogen and moisture resistant type covered electrode

Classification: ASME / AWS A5.5 E9016-G
JIS Z3211 E6216-N1M1 U

Features: ▪Suitable for one-side welding of pipes
▪Extremely good arc stability in one-side welding with relatively low currents
▪Extra low hydrogen type with excellent crack resistibility

Redrying Conditions: 350~400℃x1h

Welding Positions:



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

	C	Si	Mn	P	S	Ni	Mo
Example	0.08	0.64	1.03	0.010	0.004	0.59	0.24
Guaranty	≦0.09	0.40~0.75	0.70~1.20	≦0.020	≦0.020	0.45~0.80	0.20~0.40

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J)
Example	560	650	26	-20℃: 88
Guaranty	≧530	≧620	≧17	-

Recommended welding parameters

	2.6mm	3.2mm	4.0mm
F, HF,H	60~90A	90~130A	130~180A
VU, OH	50~80A	80~115A	110~170A
Root pass	30~80A	60~110A	90~140A

Polarity

Example	DC-EP
Guaranty	DC-EP, AC (DCEN is also suitable for root pass.)

Approvals

ABS
3YQ500 H10

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	350	5	20	30
4.0	400	5	20	53