

LC-418

For highly efficient welding of 55kgf/mm² class high tensile strength steel

AWS A5.5 E8018-G
KS D 7006 E5316
JIS Z3211 E5518-G

Applications

Welding of 55kgf/mm² class high tensile strength steel for ships, bridges, buildings and boilers.

Characteristics

LC-418 is an iron powder low hydrogen type electrode, and provides good usability with direct current applications in all-position.

The weld metal has good crack resistibility and X-ray soundness. Also it is suitable for multi-layer fillet welding in large leg length.

Notes on usage

- (1) Dry the electrodes at 350~400°C for about one hour before use.
- (2) Adopt backstep 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	Cu	Ni	Cr
0.06	0.80	0.43	0.01	0.009	0.53	0.51	0.52

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°C
520(53)	620(63)	28	70(7)

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0	
	L (mm)	350	350	400	400(450)	450
Amp.	F	55-85	90-130	130-180	180-240	250-310
	V&OH	50-80	90-115	110-170	150-200	-

• Tip Color : Blue