

LC-300T

For tack welding of 50kgf/mm² class high tensile strength steel

AWS A5.1 E7048
KS D 7006 E5016
JIS Z3211 E4948

Applications

Tack welding of 50kgf/mm² class high tensile strength steels in ships, bridges, buildings.

Characteristics

LC-300T is a low hydrogen type electrode, makes easier re-arcing. Then it gives an excellent tack welding performance.

When a proper welding current is set, it makes all-position welding possible including vertical down welding.

Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes 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
0.08	0.74	0.32	0.010	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°C
460(47)	540(55)	32	100(10)

Size & recommended current range (AC or DC +)

Dia. (mm)		3.2	4.0	5.0
L (mm)		350	400	450
Amp.	All Position	110-160	160-220	-
	F&V-down	110-160	160-220	200-260

• Tip Color : Red