

# LC-300

For welding of 50kgf/mm<sup>2</sup> class high tensile strength steel

AWS A5.1 E7016  
KS D 7006 E5016  
JIS Z3211 E4916

## Applications

Welding of 50kgf/mm<sup>2</sup> class high tensile strength steels ships, bridges, buildings and pressure vessels.

## Characteristics

LC-300 is the most widely used low hydrogen type covered electrode for all position welding of 50kgf/mm<sup>2</sup> class high tensile strength steels.

X-ray soundness and mechanical properties of the weld metal are excellent. The usabilitys such as arc smoothness, slag removal and bead appearance are good.

## Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Adopt the 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
0.07	0.98	0.53	0.014	0.010

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)
			-30°C
490(50)	560(57)	32	130(13)

## 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	80-115	110-170	150-200	-

• Approval : ABS, BV, DNV, GL, KR, LR, NK

• Tip Color : Blue