

LB-52U

FAMILIARC™

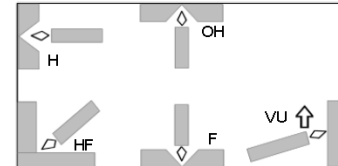
Low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

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

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

Redrying Conditions: 300~350°C x 0.5~1 hr

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
Guaranteed Range	0.05~0.10	≤ 0.75	≤ 1.60	≤ 0.020	≤ 0.020

■ Mechanical properties of all-weld metal as per AWS

	YS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	480	560	31	-29°C: 80
Guaranteed Range	≥ 400	≥ 480	≥ 22	-29°C: ≥ 27

■ Recommended welding parameters

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

Root pass: DC-EN is also suitable.

■ Polarity

AC, DC-EP

■ Approvals

AB	LR	NV	BV	NK	Others
3H10,3Y	3m,3Ym(H15)	3YH10	3,3YHH	KMW53H10	CCS

■ Packaging

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	35
4.0	400	5	20	53

Diam.	Pack / Carton	Part No.
2.6mm	5kg / 20kg	KOBE LB52-U-26
3.2mm	5kg / 20kg	KOBE LB52-U-32
4.0mm	5kg / 20kg	KOBE LB52-U-40

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