

# LB52-18

# FAMILIARC™

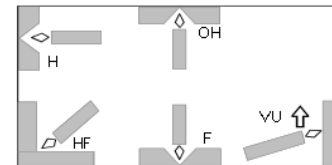
Iron powder low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

**Classification:** ASME / AWS A5.1 E7018  
EN499 E423B

**Features:** ▪ Suitable for butt and fillet welding of heavy structures  
▪ Good performance using DC-EP 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
Typical	0.07	0.59	0.97	0.013	0.007
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 (%)	CVN (J)	PWHT (°C x hr)
Typical	500	560	31	-29°C:110	AW
	420	520	32	-29°C:140	620±15x1
Guaranteed	≥ 400	≥ 480	≥ 22	-29°C ≥ 27	AW
Range	≥ 350	≥ 460	≥ 25	-29°C ≥ 27	620±15x1

**Recommended welding parameters**

	2.6mm	3.2mm	4.0mm	5.0mm
Dia.	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	65~95A	90~130A	130~190A	190~250A
VU, OH	60~90A	80~120A	110~170A	165~210A

**Polarity**

Example	AC
Guaranty	AC, DC-EP

**Approvals**

AB	LR	NV	NK
3H10,3Y	3m,3Ym(H15)	3YH10	KMW53HH

**Packaging**

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton(kg)	Weight per piece(g)
2.6	350	5	20	24
3.2	400	5	20	41
4.0	450	5	20	69

Diam.	Pack / Carton	Part No.
2.6mm	5kg / 20kg	KOBE LB52-18-26
3.2mm	5kg / 20kg	KOBE LB52-18-32
4.0mm	5kg / 20kg	KOBE LB52-18-40

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