LC-128

For highly efficient welding of 90kgf/mm^2 class high tensile strength steel

AWS A5.5 E12018-M
JIS Z3211 E8318-N4C2M2

Applications

Welding of 90kgf/mm^2 class high tensile strength steel for penstocks, pressure vessels and machinery.

Characteristics

LC-128 is an iron powder low hydrogen type electrode and provides good usability with direct current applications in all-positions.
The weld metal has good crack resistibility and X-ray soundness.

Notes on usage

(1) Dry the electrodes at 350~400℃ for about one hour before use.
(2) Store the electrodes at 100~150℃ after drying them with attention to keep away from moisture.
(3) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose, because arc striking on base metal is in danger of initiating cracking.
(4) Keep the arc as short as possible.
(5) Preheat at 150~200℃. The temperature varies in accordance with plate thickness and steel kind.
(6) Pay attention not to exceed proper heat-input because excessive heat-input causes deterioration of impact values and yield strength of weld metal.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni	Cr	Mo
0.06	1.80	0.45	0.010	0.009	0.64	0.41	2.0

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)
			-51℃
853(87)	931(95)	20	50(5)

Size & recommended current range (AC or DC +)

Dia. (mm)		3.2	4.0	5.0
L (mm)		350	400	400
Amp.	F	90-130	135-185	190-250
	V&OH	80-120	110-170	-

• Tip Color : Yellow