

# LC-318

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

AWS A5.1 E7018  
KS D 7006 E5016  
JIS Z3211 E4916

## Applications

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

## Characteristics

LC-318 is iron powder low hydrogen type electrode for all-position welding. Its usability is the best with direct current application as well as alternating current application.

## Notes on usage

- (1) Dry the electrodes at 300~350°C for 30~60 minutes before use.
- (2) Adopt back step 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	0.96	0.61	0.013	0.007

## 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
470(48)	560(57)	32	130(13)

## Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	5.5	6.0	
L (mm)	350	350	400 450	400 450	450	450	
Amp.	F	60-100	90-130	130-190	200-240	230-270	250-300
	V&OH	50-80	70-130	100-170	160-210	-	-

• Approval : ABS, BV, DNV, LR, NK

• Tip Color : Pink