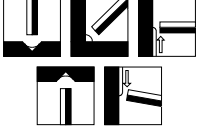


LN-15	LOW HYDROGEN ELECTRODE FOR WELDING STRUCTURAL STEELS SUBJECTED TO A SERVICE TEMPERATURE OF -50°C				DATA SHEET No. 29						
SPECIFICATION	AWS A5.5			JIS Z 3241							
CLASSIFICATION	E8016-G			DL5016-6A1							
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux is engineered to ensure the optimum weld metal properties demanded by the specification are fully met.</p> <p>The basic flux containing the appropriate alloying elements with a controlled balanced addition of iron power, is extruded onto a high purity ferritic core wire with a blend of silicates that ensures both coating strength and a coating resistant to subsequent moisture absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>Suitable for use both on AC or DC, the high arc drive combined with a fluid but quick freezing slag is ideal for site welding, particularly in the vertical up and overhead positions when no root gap exists and joint access is possible from both sides. The weld bead is convex and arc stability good.</p> <p>Metal recovery is some 95% with respect to core wire weight.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>PRESSURE VESSEL STEELS</p> <p>PLATES All grades up to BS 1501-225 FORGINGS All grades up to BS 1503-224. PIPES LT50 quality of grade 410 in BS 3603:1977</p> <p>Such steels and similar are used for the fabrication of LPG tankers and storage vessels.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Ni	Fe			
	MIN *	0.03	0.5	0.3	-	-	1.2				
	MAX	0.10	1.5	0.5	0.02	0.03	1.8				
	TYPICAL	0.05	1.2	0.4	0.01	0.02	1.5	Bal			
	* Undiluted weld metal shall have the minimum of at least one of the element specified on AWS A5.5-2006										
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm ²	550	590							
	0.2% Proof stress	N/mm ²	460	490							
	Elongation on 4d	%	19	28							
	Reduction of Area (RA)	%	-	65							
	Impact energy -60°C	J	-	80							
WELDING AMPERAGE AC or DC+	Ø (mm)	2.6	3.2	4.0	5.0						
	MIN	50	75	130	180						
	MAX	85	125	170	220						
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.										
RELATED PRODUCTS	Please contact our Technical Department for detail										