

FAMILIARC™ **LB-52**

**Welding Electrode for Mild Steel
& 490 MPa High Tensile Steel**



Application

FAMILIARC™ LB-52 is a low hydrogen type welding electrode suitable for welding of mild steel and 490 MPa high tensile steel in all positions.

FAMILIARC™ LB-52 is suitable for welding of ships, bridges, building, pressure vessels and pipes.

Features

- ◆ Stable arc
- ◆ Excellent slag detachability
- ◆ Smooth bead appearance
- ◆ Excellent X-ray soundness and mechanical properties

LB-52

Available sizes and recommended welding current

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	400	450
Welding current (A)	F	55~85	90~130	130~180	180~240
	VU & OH	50~80	80~120	110~170	150~200

Current type : AC, DC-EP

Typical chemical composition of all weld-metal (%)

C	Si	Mn	P	S
0.08	0.60	0.94	0.011	0.006

Typical mechanical properties of all weld-metal

0.2% OS (MPa)	TS (MPa)	El (%)	IV at -30°C (J)	PWHT (°C x hr)
500	570	32	120	As welded
420	520	33	150	620±15 x 1

Notes on usage

- ◆ Redrying the electrode at 300~350°C for 30~60 minutes prior to use.
- ◆ Use back step arc starting technic to prevent blowholes at the starting point.
- ◆ Keep the arc length as short as possible.
- ◆ Use wind screen when the wind is strong.

Shipping Approval

NK	LR	ABS	BV	DNV	GL
KMW53HH	DXVuO, BF, 3Ym, H15	3H10, 3Y	3, 3YH	3YH10	3YH15

DISCLAIMER

• Information in this booklet such as chemical compositions and mechanical properties is typical or example for explaining the features and performance of our products, and it does not guarantee otherwise specified.
• Information contained herein is subject to change without notice. Please kindly contact KOBELCO for latest information

» For Technical Consultation, please contact **Technical Service.**

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