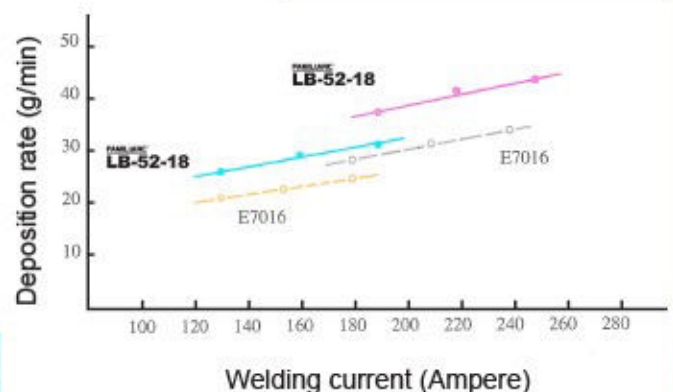


FAMILIARC™**LB-52-18****Welding Electrode for Mild Steel and 490 MPa High Tensile Steel****Application**

FAMILIARC™ LB-52-18 is an iron powder low hydrogen type electrodes suitable for welding of mild steel and 490 MPa high tensile steel of ships, bridges, buildings, pressure vessels, storage tanks and pipes in all position

Features

- ◆ **FAMILIARC™ LB-52-18** contains iron powder in coating flux. It therefore, provides higher deposition rate than usual low hydrogen type electrodes.
- ◆ Superior mechanical properties.
- ◆ **FAMILIARC™ LB-52-18** can be used with both AC and DC.
- ◆ **FAMILIARC™ LB-52-18** provides stable arc, better slag removability and smooth bead appearance.



LB-52-18

Available sizes and recommended welding current (AC, DC-EP)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	400	450	450
Welding current	F	65-95	90-130	130-190	190-250

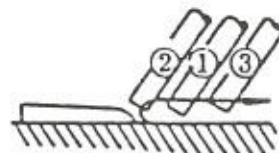
Typical mechanical properties of all weld-metal

0.2% OS (MPa)	TS (MPa)	El (%)	IV at -29°C (J)	PHWT
500	560	31	110	AW
420	520	32	140	620° C x 1 Hr

Typical chemical composition of all weld-metal (%)

C	Mn	Si	P	S
0.07	0.97	0.59	0.013	0.007

Backstep arc starting technique



Notes on usage

- ◆ Redrying the electrode at 300~350°C for 30~60 minutes prior to use.
- ◆ Use back step arc starting technique 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

AB	LR	NV
3 H10, 3Y	3, 3Y H15	3H10

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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JQA-QM3667
JQA-EM5680