

TRUSTARC™ LB-52NS

Arc Welding Electrode for High Tensile Steel



Application

TRUSTARC LB-52NS is a highly reputed, dependable electrode for various low temperature application such as LPG carriers, storage tanks, offshore structures and heat exchangers.

Features

Workability

- ◆ Applicable to use for all welding position
- ◆ Better impact values at temperature down to -60°C
- ◆ Good CTOD properties at temperature down to -30°C
- ◆ Both AC and DC-EP can be used
- ◆ Vacuum pack

LB-52NS

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

| Diameter (mm) | | 2.6 | 3.2 | 4.0 | 5.0 |
|-----------------------|----------|-------|--------|---------|---------|
| Length (mm) | | 300 | 350 | 400 | 450 |
| Welding current (Amp) | F, HF, H | 55~85 | 90~130 | 130~180 | 180~240 |
| | VU, OH | 50~80 | 80~120 | 110~170 | 150~200 |

Notes on usage

- ◆ Drying the electrode at 350℃~400℃ for about one hr before use.
- ◆ Keep the arc length as short as possible.
- ◆ Pay attention not to exceed proper heat-input because excessive heat-input causes deterioration of impact values of weld metal
- ◆ Re-dry of electrode is not needed within 8 hr after opened.
- ◆ If more than 8 hr, re-dry at 350℃~400℃ for 1 hr [APPLICABLE FOR VACUUM PACE ONLY]

Typical mechanical properties of all weld-metal

| | 0.2% OS (MPa) | T.S (MPa) | El (%) | I.V (J) | IV at -29(°C)h |
|----------------------|---------------|-----------|--------|-------------|----------------|
| Typical (AC) | 490 | 580 | 29 | 130 @ -60℃ | AW |
| | 470 | 570 | 31 | 120 @ -60℃ | 620x1 |
| Guaranty (AC, DC-EP) | ≥ 393 | ≥ 483 | ≥ 27 | ≥ 27 @ -60℃ | AW |
| | ≥ 393 | ≥ 483 | ≥ 27 | ≥ 27 @ -60℃ | 620x1 |

Typical chemical composition of all weld-metal (%)

| C | Si | Mn | P | S | Ni | Ti | B |
|------|------|------|------|-------|------|-------|--------|
| 0.06 | 0.36 | 1.38 | 0.01 | <0.01 | 0.46 | 0.019 | 0.0027 |

Diffusible Hydrogen Content Test method : JIS Z3118 (Gas chromatography method)

| Size | Atmospheric Condition | Diffusible hydrogen content (ml/100g) | | | | |
|------|-----------------------|---------------------------------------|-----|-----|-----|-----|
| 4.0 | 20℃x45% R.H | 1 | 2 | 3 | 4 | Avg |
| | | 3.4 | 3.8 | 4.1 | 4.1 | 3.9 |

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

Shipping Approval

| NK | LR | ABS | BV | DNV |
|------------------------|-------------|---------------|-------------------|-------------------------------|
| KMW/54Y40 KMW/L3H10 | 5Y40m (H15) | 3Y, 4Y400 H10 | 4Y40M, HH (KV-60) | 5Y40H10 NV2-4 (L), 4-4 (L) |



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

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