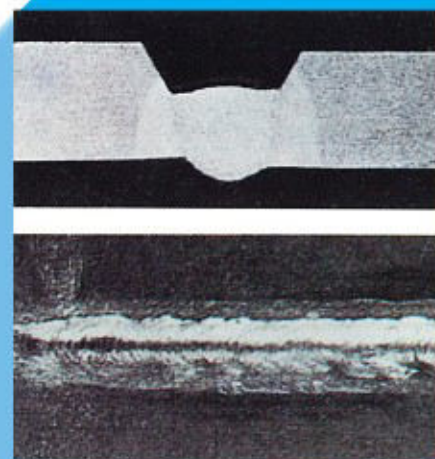


FAMILIARC™**LB-52U****Welding Electrode for Mild Steel and 490 MPa High Tensile Steel****Application**

FAMILIARC LB-52U is a low hydrogen type electrode suitable for root pass welding of pipe and general butt joints of mild steel and 490 MPa high tensile steel.

Features

- ◆ **FAMILIARC LB-52U** provides more stable arc than other low hydrogen type electrodes.
- ◆ **FAMILIARC LB-52U** provides better slag removability.
- ◆ **FAMILIARC LB-52U** provides beautiful bead appearance and penetration.



Beautiful back side bead appearance obtained by **FAMILIARC LB-52U** in root pass welding

Typical chemical composition of all weld-metal (%)

C	Si	Mn	P	S
0.08	0.64	0.86	0.012	0.008

Shipping Approval

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

LB-52U

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

Diameter (mm)		2.6	3.2	4.0
Length (mm)		350	400	400
Welding current (A)	Root pass	30-80	60-110	90-140
	F	60-90	90-130	130-180
	VU & OH	50-80	80-120	110-170

Typical mechanical properties of all weld-metal

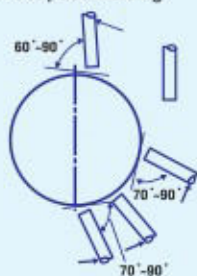
0.2% OS (MPa)	TS (MPa)	El (%)	IV at -29°C (J)
480	560	31	80

Notes on usage

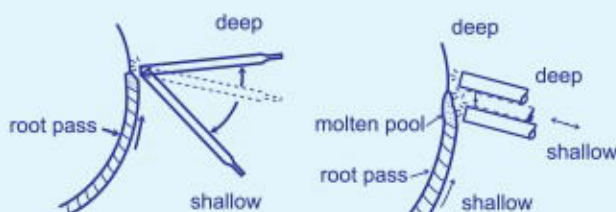
- ◆ Redrying the electrode at 300~350°C for 30~60 minutes prior to use.
- ◆ Use back step arc starting technique to prevent blowholes at the starting point.
- ◆ In cutting off the arc, transfer it to the groove face (as shown below) in order to prevent a crater-crack. Then grind off the end of previous bead to get a smooth reverse bead joining and to prevent defects.

Techniques to control penetration of root bead

Correct electrode angle in root pass welding

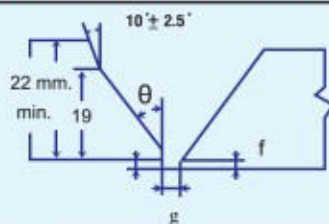
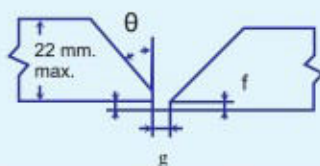


Correct electrode angle



Techniques to control penetration of root bead

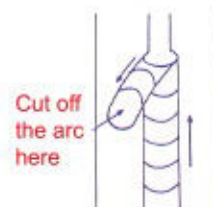
Joint preparation



Bevel angle θ (mm)	Root face f (mm)	Root gap g (mm)	Misalignment (mm)
30-40	0.4-2.0	2.0-3.2	1.6 max.



Backstep technique



Stopping arc

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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