

FAMILIARC™

LH-2000

Welding Electrode for Welding of 490 N/mm² High Tensile Steel



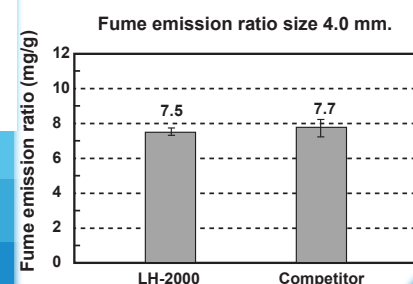
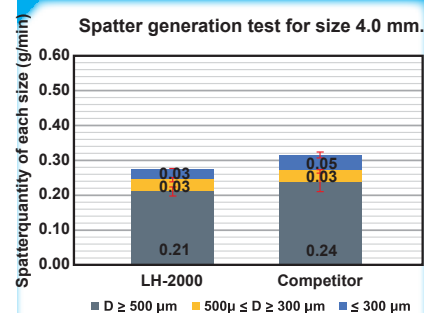
Application

FAMILIARC LH-2000 is a low hydrogen type covered electrode for welding of mild steel and 490 N/mm² steel in all positions. It is suitable for welding of steel structure, repairing work of machine parts and under layer before hardfacing.

Features

Re-drying conditions : 300-350° C x 0.5-1 hr

- ◆ Excellent mechanical properties
- ◆ Good penetration
- ◆ Better usability compared with conventional lowhydrogen type
- ◆ Smooth bead appearance and better slag removal
- ◆ Suitable for butt and filler welding of heavy structure
- ◆ Soft arc and good arc stability
- ◆ Good re-arc ability
- ◆ Good slag detachability
- ◆ Increasing tensile strength and good impact property at - 30° C
- ◆ Less spatter and fume emission
- ◆ Suitable welding for AC and DC± polarity



LH-2000

Typical chemical composition of all weld-metal (wt%)

Product	Size(mm)	C	Si	Mn	P	S
LH-2000	3.2	0.08	0.58	1.27	0.009	0.001
	4.0	0.08	0.67	1.39	0.009	0.001
AWS A5.1 E7016		≤ 0.15	≤ 0.75	≤ 1.60	≤ 0.0035	≤ 0.0035

Typical mechanical properties of all weld metal

Product	Size (mm)	Tensile properties			Charpy impact vE -30° C (J)	Hardness (HV ₃₀)
		0.2% OS (MPa)	TS (MPa)	EI (MPa)		
LH-2000	3.2	498	603	32	180	224
	4.0	529	614	33	151	212
AWS A5.1 E7016		≥ 400	≥ 490	≥ 22	Avg. ≥ 27	--

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

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

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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