

L-55LH

JIS Z 3211 E4916-U

☆AWS A5.1 E7016

For 490MPa High Tensile Strength Steel

SMAW

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APPLICATIONS

Welding of 490MPa High Tensile Strength Steel for ships, structures, bridges and pressure vessels.

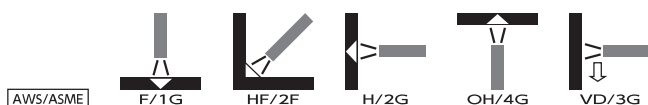
CHARACTERISTICS

L-55LH is a low hydrogen type electrode for all positions. Diffusible hydrogen in the weld metal 100 grams is 5mL below. Therefore the weld metal shows excellent crack resistance and X-ray quality. Weldability and mechanical properties are good due to arc stable. And vertical and overhead welding is very easy.

GUIDELINES FOR USAGE

1. Electrodes should be redried at 300~350°C for 60 minutes before use.
2. Backstep method should be applied to prevent blowholes and pits at arc starting. Arc length should be kept as short as possible during welding.
3. All water, rust and oil in groove should be completely removed to prevent cracks and blowholes.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S
0.07	0.61	1.12	0.014	0.001

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at -30°C, J
466	577	28	141

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.6	3.2	4.0	5.0	6.0	8.0
Length (mm)		300	400	450	450	450	450
Current A	F, HF, H	60~110	70~140	120~190	190~240	250~300	340~390
	VU, OH	60~90	60~130	90~150	130~170	—	—

Identification color: End-light blue, secondary-pink

WELDREAM™