

FAMILIARC™

LB-55U

AWS A5.5 / ASME SFA5.5 E8016-G



Low Hydrogen Type Electrode For One-side Welding Of Pipes

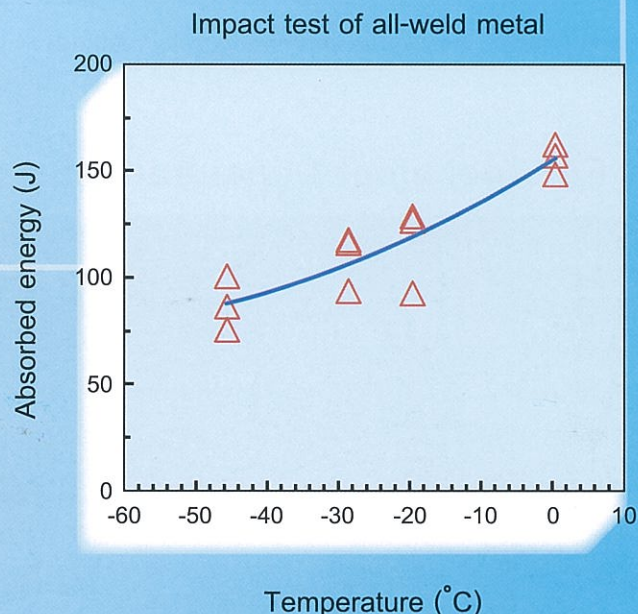


Application

FAMILIARC LB-55U is a low hydrogen type covered electrode for all welding position. It especially use for one side welding of X65 piping. **FAMILIARC LB-55U** is also able use for welding of general structures and high tensile steels. It provides good notch toughness at low temperature down to -40 °C. It is applicable both of DC and AC polarity.



Root bead appearance



Available sizes and recommended welding current (AC and DCEP)

Diameter (mm)		2.6	3.2	4.0
Length (mm)		350	400	450
Welding current (Amp)	F, HF, H	60 - 90	90 - 130	130 - 180
	VU, OH	50 - 80	80 - 120	110 - 170
	Root pass*	30 - 80	60 - 110	90 - 140

*DCEN is also suitable for root pass.

Typical mechanical properties of all-weld metal

Mechanical properties of all-weld metal					PWHT condition
	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	
Example	573	621	31	87 at -46°C	AW
Guaranty	≥ 460	≥ 570	≥ 20	≥ 32 at -40°C	AW

Typical chemical composition of all-weld metal

	Chemical composition of all-weld metal (wt%)				
	C	Si	Mn	P	S
Example	0.06	0.49	1.70	0.015	0.005
Guaranty	≤ 0.10	≤ 0.75	1.40 - 2.25	≤ 0.030	≤ 0.030

Typical diffusible hydrogen content

Diffusible hydrogen content* (ml/100g)				
1	2	3	4	Avg.
4.0	3.5	3.9	3.7	3.8

* According to AWS A4.3 (Gas chromatography method)

Notes on usage

- Re-dry the electrode at 350-400°C for 60 minutes before use.
- Store the electrode in an oven (100-150°C) near the welding area after finished re-drying.
- Use the backstep technique directly in the welding groove or strike an arc on a small steel plate to prevent cracking at the arc starting.
- Reverse side bead with good appearance is obtained with proper current and optimum root gap.
- Keep the arc length as short as possible.

THE GUARANTEE:

QIQ

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International slogan of Kobelco Welding Group

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

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