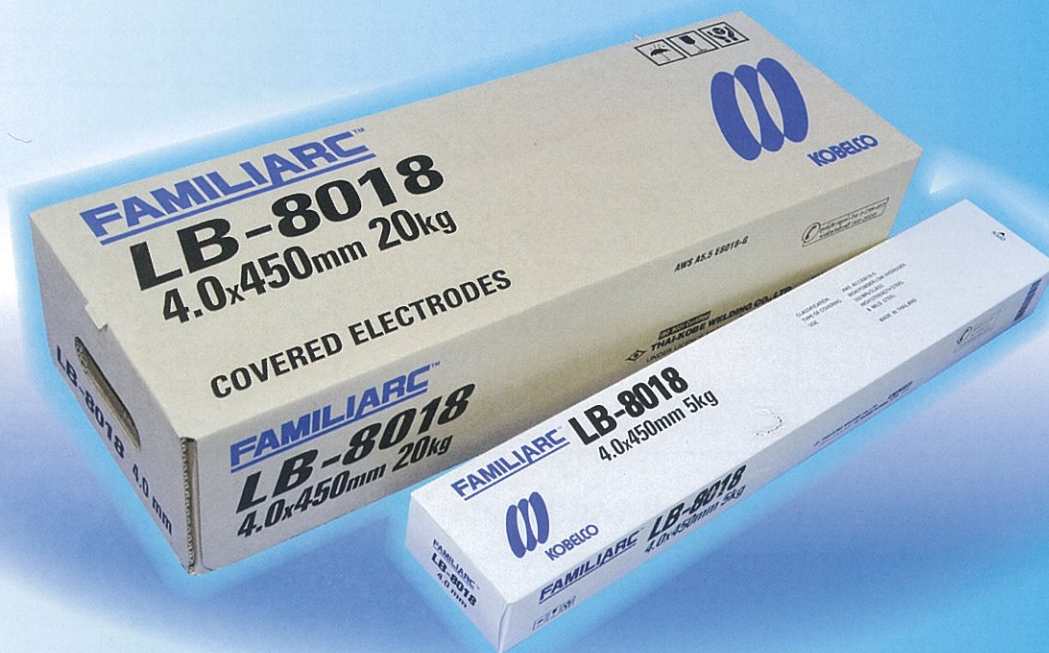


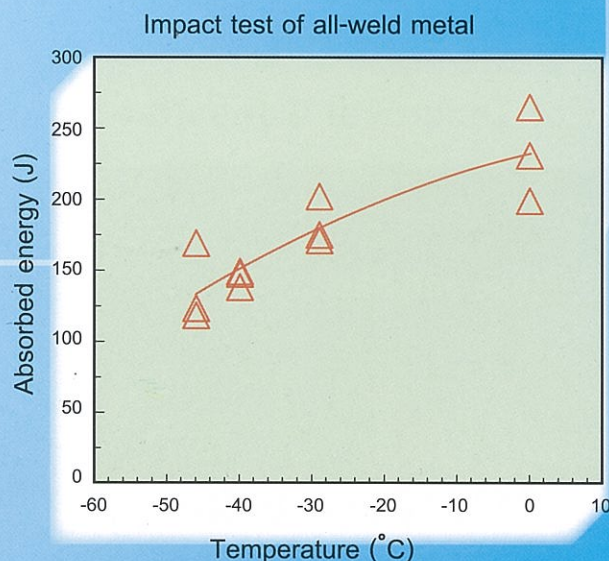
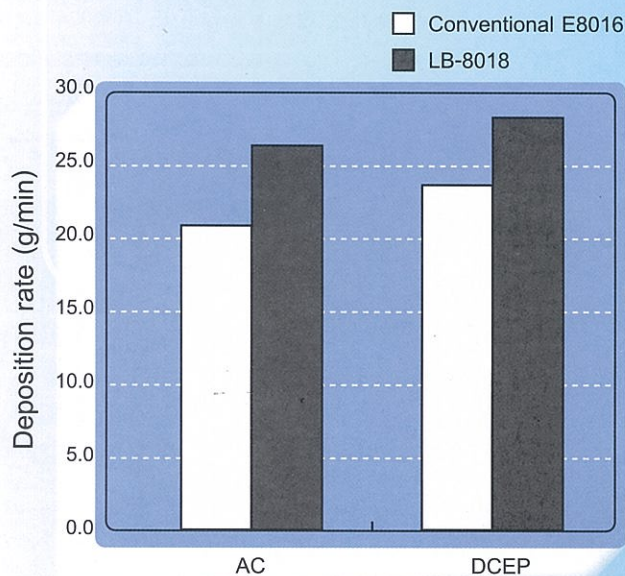
FAMILIARC™**LB-8018****AWS A5.5 / ASME SFA5.5 E8018-G**

Iron Powder Low Hydrogen Type Covered Electrode for Pipes
and High Tensile Steels



Application

FAMILIARC LB-8018 is an iron powder low hydrogen type covered electrode for all welding position. It suitable uses for X65 pipe welding. **FAMILIARC LB-8018** 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.



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	65 - 95	90 - 130	130 - 190
	VU, OH	60 - 90	80 - 120	110 - 170

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	525	600	32	137 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	0.04	0.24	1.66	0.011	0.003
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
4.8	4.6	4.8	4.9	4.8

* 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.



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

THAI-KOBE WELDING CO., LTD.

Head Office and Factory

500 Moo 4 Soi 1 Bangpoo Industrial Estate, Sukhumvit Road, Praeksa, Muang, Samutprakarn 10280, Thailand
 Tel : (+66)-2-324-0588~91 , Fax : (+66)-2-324-0797
 Web site : <http://www.thaikobe.com>

Bangkok Office

10th Fl., Sathorn Thani II Building, 92/23 North Sathorn Road, Silom, Bangrak, Bangkok 10500, Thailand
 Tel : (+66)-2-636-8650~2 , Fax : (+66)-2-636-8653

