

Characteristics:

LKE-7010-A1 is a high cellulose type electrode for DC(+) welding . The welding can be done in all positions with good crack resistance, deep penetration, stable arc, and good performance.

Applications:

It is especially suitable for welding of the pipes, high pressure pipes, oil tanks, and boilers due to its good X-ray soundness.

Notes on Usage:

- 1.Dry the electrodes at 70-100°C for 30-60 minutes before use.
- 2.Pre-heat the work piece at 100-200°C and PWHT at 620-680°C

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Mo
0.090	0.57	0.20	0.014	0.011	0.52

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	PWHT
480	570	28	620 °C x1hr

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Amps	F	50-80	80-120	110-160	150-200
	V&OH	40-70	70-110	90-150	120-180
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20