

**Characteristics:**

LKT-80B2 with 12.5%Cr and 0.5%Mo, is designed for welding low-alloy steels with high tensile strength and creep-resistance steels such as ASTM type A199-76, A200-75, A213-76d, A335-76, A369-76, A387-76.

Applications:

It is suitable for welding of pipelines in pressure vessels and boilers with operating temperatures up to about 500°C

Notes on Usage:

1. Use DC(-) current and 100%Argon gas at proper flow rate.
2. In order not to derogate the weld metal quality from particle. Be sure to clean up the contaminations on base metal and welding seam.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Mo	Cu
0.09	0.60	0.49	0.010	0.007	1.42	0.52	0.15

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	PWHT
529	637	27	620°C x1hr

Sizes available

Diameter (mm)	1.6	2.0	2.4	3.2
Length(mm)	915	915	915	915
Weight per box(kg)	5	5	5	5