



AWS A 5.18 ER70S-G
JIS Z3316 YGT50

Characteristics:

It is designed for welding of mild steel and 490N/mm² grade steel. Commonly used is butt or fillet welding. LKT-50 is an all-position welding rod for TIG welding. It is especially suitable for the root pass of pipe welding. Use DC(-) polarity.

Applications:

It is suitable for welding of high pressure piping for shipbuilding, petrochemistry and nuclear power plant, etc.

Notes on Usage:

1. Use 99.997% purity of Ar as shielding gas.
2. Clean the surface of base metal to prevent contamination.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cu	Fe
0.083	1.26	0.85	0.015	0.005	0.015	Bal.

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30 °c J
440	550	33	62

Sizes and recommended current range (DC <->)

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	1000	1000	1000	1000
Weight per box (kg)	5	5	5	5