



AWS A5.18 ER70S-6
JIS Z3316 YGT50

Characteristics:

LKT-56 is designed for welding of mild steel and 490N/mm² grade steel. Commonly used is butt or fillet welding. As an all-position welding rod for TIG welding, it is especially suitable for the root pass of pipe welding.

Applications:

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

Notes on Usage:

- 1.100% Argon shielding gas with 99.997% high purity is recommended and the flow rate must be properly controlled. The flow rate is recommended 7-12l/min when arc current is 100-200Amp and it goes up to 12-15l/min when arc current rises to 200-300Amp.
2. Select right gas cup size and employ proper stick out of tungsten electrode.
3. To obtain a very clean weld pool, keep the weld plate free from dirt, rust, paint and any other atmospheric contamination.
4. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
0.08	1.53	0.80	0.015	0.011	0.008	0.022	0.021	0.006	0.044

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30 °C J
460	550	35	96

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