

S-86LTH

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E8016-G

ABS AWS A5.5 E8016-G (-60°C ≥47 J)

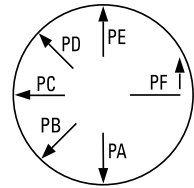
Applications

- OffShore Structure
- LPG vessel
- LPG storage
- Heat Exchanger

Features

- 55kg grade low-hydrogen high tensile electrode (-60°C)
- Ni, Ti, B contained in the weld-metal.
- Great tensile strength in low-temperature
- Anti- Low temperature crack (Low hydrogen)

Welding Position



Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X

0.5~1hr

Diameter / Packaging

Diameter	Length	Vacuum				Steel can	
		packet	carton	packet	carton	packet	carton
		1.5kg (3.3lbs)	15Kg (33lbs)	5kg (11lbs)	20kg (44lbs)	4.5Kg (9.9lbs)	18Kg (40lbs)
2.6 (3/32)	350 (14)	✓		✓		✓	
3.2 (1/8)	350 (14)	✓		✓		✓	
4.0 (5/32)	400 (16)	✓		✓		✓	
5.0 (3/16)	400 (16)	✓		✓		✓	

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Tl	B
0.05	0.29	1.49	0.01	0.002	0.91	0.022	0.003

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN Impact Test J J (ft-lbs)	Heat Treatment
521 (75,600)	600 (87,000)	28	-45 (-49) -60 (-76)	143 (106) 125 (92)	AW
502 (72,800)	571 (82,800)	31.4	-45 (-49) -60 (-76)	137 (101) 123 (91)	625°C(1157°F) X 8hr

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)
Flat (1G-PA)	60-90	90-140	130-190	180-250
3G (PF) & 4G,5G (PE)	50-80	80-120	120-170	150-200