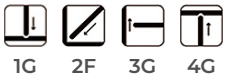
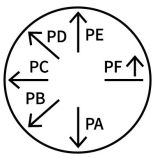
S-86LTH

Classification

AWS A5.5/ASME SFA-5.5 E8016-G

Welding Positions





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)

Polarity

AC or DC +

Application Areas

- Offshore structures
- LPG vessels, LPG storage
- Heat exchangers

Redrying Conditions

350~400°C (662~752°F) X 0.5~1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Ti	B
0.06	0.40	1.42	0.015	0.005	0.93	0.02	0.003

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
As-weld	531(77)	616(89)	30	-45(-50) -60(-75)	103(76) 73(54)
625*8hr	503(73)	588(85)	31	-45(-50) -60(-75)	106(78) 74(55)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
2.6(3/32)	350(14)	60-90	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-140	
4.0(5/32)	400(16)	130-190	
5.0(3/16)	400(16)	180-250	