



CHUUA ELECTRODE

For high tensile strength steel

Type of covering	Brand name	Size (mm)	Equivalent specification	Welding position	Type of current	Typical chemical composition of all-weld-metal(%)								Typical mechanical properties of all-weld-metal				Main use
						C	Si	Mn	P	S	Ni	Mo	Cr	Y.P N/mm ² {kgf/mm ² }	P.S N/mm ² {kgf/mm ² }	EI. (%)	I.V J {kgf.m}	
Low hydrogen type	LB-52h	3.2-6.0	AWS E7016 JIS D5016	F,V,OH,H	AC or DC(+)	0.08	0.50	1.00	0.015	0.008	—	—	—	488 {50}	559 {57}	31	248 {25.3}(-29℃)	Welding of 500N/mm ² class high tensile steel in ships, buildings and pressure vessels.
	LB-52LF	3.2-6.0	AWS E7016 JIS D5016	F,V,OH,H	AC or DC(+)	0.08	0.50	1.00	0.015	0.008	—	—	—	488 {50}	559 {57}	31	163 {17} (-29℃)	Welding of 500N/mm ² class high tensile steel in ships, buildings and pressure vessels.
	LA-50LH	3.2-6.0	AWS E7016 JIS D5016	F,V,OH,H	AC or DC(+)	0.08	0.60	1.13	0.04	0.04	—	—	—	490 {50}	560 {57}	32	150 {15} (-29℃)	Welding of 500N/mm ² class high tensile steel. Excellent mechanical properties and high resistance to cracking.
	LA-50-G	3.2-6.0	AWS E7016-G JIS D5016	F,V,OH,H	AC or DC(+)	0.07	0.78	1.05	0.04	0.04	—	—	—	530 {54}	630 {64}	30	90 {9} (-29℃)	Welding of steel which is subjected to elevated temperature such as those found in the power piping and boiler industries.
	LS-7	3.2-6.0	AWS E8016-G JIS D5316	F,V,OH,H	AC or DC(+)	0.08	0.53	1.15	0.012	0.007	—	—	—	533 {54}	634 {65}	32	141 {15} (-29℃)	Welding of 550N/mm ² class high tensile steels of ships, bridges and buildings.
	LA-60	3.2-6.0	AWS E9016-G JIS D5816	F,V,OH,H	AC or DC(+)	0.08	0.55	1.30	0.012	0.008	0.69	0.30	—	539 {55}	649 {66}	29	95 {10} (-29℃)	Welding of 600N/mm ² class high tensile steels of pressure vessels, bridges, penstocks.
	LA-70	3.2-6.0	AWS E10016-G JIS D7016	F,V,OH,H	AC or DC(+)	0.08	0.55	1.30	0.012	0.008	1.60	0.40	0.30	649 {66}	735 {75}	23	82 {8} (-20℃)	Welding of 700N/mm ² class high tensile steels of pressure vessels, bridges, penstocks.
	LA-80	3.2-6.0	AWS E11016-G JIS D8016	F,V,OH,H	AC or DC(+)	0.08	0.55	1.30	0.012	0.008	1.60	0.30	0.50	666 {68}	804 {82}	22	76 {8} (-20℃)	Welding of 800N/mm ² class high tensile steels of pressure vessels, bridges, penstocks.
Iron powder, low hydrogen type	LS-78	3.2-6.0	AWS E7018	F,V,OH,H	AC or DC(+)	0.08	0.60	1.00	0.012	0.011	—	—	—	513 {52}	585 {60}	29	221 {226} (0℃)	Welding of 500N/mm ² class high tensile steels in ships, buildings and pressure vessels.
	LS-526	3.2-8.0	AWS E7028 JIS D5026	F,H-Fil	AC or DC(+)	0.07	0.23	0.58	0.012	0.010	—	—	—	490 {50}	539 {55}	28	139 {14.1} (-18℃)	High deposition efficiency welding of flat and horizontal fillets, as well as deep groove joints in 500N/mm ² high tensile steels.
	LS-526LF	3.2-8.0	AWS E7028 JIS D5026	F,H-Fil	AC or DC(+)	0.07	0.23	0.58	0.012	0.010	—	—	—	490 {50}	539 {55}	28	139 {14.1} (-18℃)	High deposition efficiency welding of flat and horizontal fillets, as well as deep groove joints in 500N/mm ² high tensile steels.
	LS-918M	3.2-6.0	AWS E9018-M	F,V,OH,H	AC or DC(+)	0.07	0.51	1.10	—	1.58	0.20	—	—	570 {58}	670 {68}	30	90 {9} (-51℃)	Welding of low alloy high tensile steels having tensile properties of 600-700N/mm ² .
	LS-1018M	3.2-6.0	AWS E10018-M	F,V,OH,H	AC or DC(+)	0.07	0.46	1.35	0.14	1.63	0.28	—	—	640 {65}	750 {77}	29	70 {7} (-51℃)	Welding of low alloy high tensile steels having tensile properties of about 700-800N/mm ² .
	LS-1118M	3.2-6.0	AWS E11018-M	F,V,OH,H	AC or DC(+)	0.08	0.41	1.49	0.32	1.86	0.32	—	—	720 {73}	820 {84}	23	60 {6} (-51℃)	Welding of low alloy high tensile steels having tensile properties of about 750-850N/mm ² such as HY80 etc.
	LS-1218M	3.2-6.0	AWS E12018-M	F,V,OH,H	AC or DC(+)	0.08	0.30	1.46	0.98	1.86	0.41	—	—	810 {82}	950 {97}	20	50 {5} (-51℃)	Welding of low alloy high tensile steels having tensile properties of about 850-950N/mm ² .