



CHUUA ELECTRODE

For low temperature service 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	Ni	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	LA-50N	2.6-6.0	AWS E7016-G JIS DL5016-4AO	F,V,OH,H	AC or DC(+)	0.08	0.42	1.35	0.47	490 {50}	570 {58}	30	130 {13} (-45°C)	Welding of aluminium-killed steels to be used at low temperature. LPG tankers and LPG gstorage tanks etc.
	LA-50N1	2.6-6.0	AWS E7016-G JIS DL5016-6A1	F,V,OH,H	AC or DC(+)	0.07	0.37	1.45	1.37	520 {53}	590 {60}	30	130 {13} (-60°C)	Welding of aluminium-killed steels to be used at low temperature. LPG tankers etc.
	LA-86C1	2.6-6.0	AWS E8016-C1 JIS DL5016-6P2	F,V,OH,H	AC or DC(+)	0.07	0.32	0.90	2.38	520 {53}	600 {61}	30	70 {7} (-73°C)	Welding of 2.5%Ni steels used in machinery for low temperature.
	LA-86C2	2.6-6.0	AWS E8016-C2 JIS DL5016-6P3	F,V,OH,H	AC or DC(+)	0.07	0.45	1.10	3.46	500 {51}	610 {62}	30	130 {13} (-60°C)	Welding of 3.5%Ni steels used in machinery for low temperature.
Iron powder, low hydrogen type	LA-78N	2.6-6.0	AWS E7018-1	F,V,OH,H	AC or DC(+)	0.07	0.58	1.38	0.15	510 {52}	590 {60}	32	130 {13} (-45°C)	Welding of aluminium-killed steels to be used at low temperature. LPG tankers and LPG storage tanks etc.
	LA-88C1	2.6-6.0	AWS E8018-C1	F,V,OH,H	AC or DC(+)	0.06	0.60	0.98	2.41	500 {51}	600 {61}	32	130 {13} (-60°C)	Welding of 2.5%Ni steels used in machinery for low temperature.
	LA-88C2	2.6-6.0	AWS E8018-C2	F,V,OH,H	AC or DC(+)	0.07	0.32	1.12	3.45	570 {58}	650 {66}	22	60 {6} (-73°C)	Welding of 3.5%Ni steels used in machinery for low temperature.
	LA-88C3	2.6-6.0	AWS E8018-C3	F,V,OH,H	AC or DC(+)	0.07	0.45	0.91	1.03	530 {54}	600 {61}	31	60 {6} (-40°C)	Welding of high tensile steels to be used at low temperature and 1%Ni steel.