

# S-78LTH

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E7018-G  
EN ISO 2560-A-E46 5 1Ni B 3 2 H5

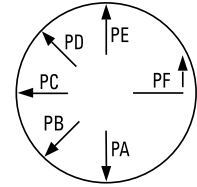
## Applications

- Low temperature strength steel
- Offshore structure
- LPG, LNG storage tank

## Features

- Low-Hydrogen electrode
- Iron powder and low hydrogen type electrode (high efficiency)
- Good impact value at -60°C
- Vacuum sealed package available (HDM ≤ 5ml/100g)

## Welding Position



## Current

AC or DC +

## Redrying Conditions

350~400°C (662~752°F) X 1hr

## Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)	✓		✓		✓		✓	
3.2 (1/8)	350 (14)	✓		✓		✓		✓	
4.0 (5/32)	400 (16)	✓		✓		✓		✓	
5.0 (3/16)	400 (16)	✓		✓		✓		✓	

SM/AW

SAW

GM/AW

GT/AW

FC/AW

Non-FERROUS

APPENDIX

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

C	Si	Mn	P	S	Ni	Ti	B
0.06	0.23	1.25	0.015	0.004	0.73	0.023	0.003

### Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
525 (76,100)	600 (87,000)	32	-45 (-51)	165 (121)
			-60 (-76)	113 (83)

### 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)	400 (16)	450 (18)	450 (18)
F	60~90	90~140	130~190	180~240
V-up, OH	50~80	80~120	120~170	150~200