

LION 27

International Standards:

AWS SFA 5.1 : E 6019
 JIS Z 3211 : D 4301
 DIN 1913 : E 43 32 AR 7
 DIN EN 499 : E 35 0 RA 12

Applications and Properties :

Lion 27 is suitable for butt or fillet welding of mild steel (20 mm less) in all positions. It is hard to cause slag inclusion and lustrous bead can be obtained. The weld metal has good crack resistance, good tensile strength and excellent toughness.

Aplikasi dan Penggunaan :

Lion 27 sangat cocok untuk pengelasan butt dan fillet dari mild steel pada segala posisi. Inklusi tidak mungkin terjadi dan hasil lasnya sangat baik. Hasil pengelasan memiliki ketahanan terhadap retak yang baik, tensile strength yang tinggi, serta keuletan yang sempurna.

Typical Chemical Analysis of Deposited Metal (%) :

C	Mn	Si	P	S
0,08	0,45	0,08	0,014	0,008

Typical Mechanical Properties of Deposited Metal :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact Value (Joule)	
			-20°C	-40°C
420	460	28	69	-

Size & Recommended Current Range (AC or DC) :

Size (mm)	2,6 x 350	3,2 x 350	4,0 x 400	5,0 x 400
Amperages (Amp)	50 - 90	80 - 130	130 - 180	170 - 240
Weight / pack (kgs)	5	5	5	5
Weight / carton (kgs)	20	20	20	20

Welding Positions :


Redrying: not required
 If necessary: 120°C/1h



SYMBOL OF QUALITY

Manufactured by:

PT. Lion Superior Electrodes

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