

NITTETSU L-55

AWS A5.1 E7016 Approval : ABS, LR, DNV GL, BV



WELDREAM®
*Rod**

APPLICATIONS

Welding of 490MPa high tensile steel for ships, structures, bridges and pressure vessels.

CHARACTERISTICS

NITTETSU L-55 is a low hydrogen type electrodes for all positions. Weld metal shows excellent crack resistance, mechanical properties and X-ray quality. Vertical and overhead welding is very easy.

GUIDELINES FOR USAGE

- ① Electrode should be redried at 300~350° C for 60 minutes before use.
- ② Backstep method should be applied to prevent blowholes and pits at arc starting and arc length should be kept as short as possible during welding.
- ③ All water, rust and oil in groove should be completely removed to prevent cracks and blowholes.

WELDING POSITION



CHEMICAL COMPOSITION OF ALL WELD METAL (%)

Brand Name	C	Si	Mn	P	S	Ni	Cr	Mo	V
NITTETSU L-55	0.07	0.67	1.17	0.015	0.001	0.02	0.03	0.01	0.005
AWS A5.1 E7016	≤0.15	≤0.75	≤1.60	≤0.035	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08

MECHANICAL PROPERTIES OF ALL WELD METAL

Brand Name	Yield Point, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at -30°C, J
NITTETSU L-55	470	576	35	186
AWS A5.1 E7016	≥400	≥490	≥22	≥27