

AquaForce LC

CATEGORY	SMAW Stick Electrodes																											
TYPE	The ultimate under water welding electrode with extreme low carbon content.																											
APPLICATIONS	Welding standard ship steel grades A, B & D in submerged conditions in case standard well known underwater electrodes fail to offer proper strength exceeding the requirements for AWS D3.6M-99 class 'A'.																											
PROPERTIES	AquaForce LC is the first electrode that was developed with "Hydrophobic sand" to offer the best possible moisture resistance. This thick coated electrode is also developed to offer best possible performance in all positions including PC, PE and PG position down to 55 meter of water depth. The special analysis of this electrode (extreme low carbon) was chosen to avoid loss in strength due to the high cooling rate (T8-5) when welding submerged.																											
CLASSIFICATION	AWS	A 5.1: E 6013																										
	EN ISO	2560-A: E 42 0 RC 11																										
	DIN	1913: E 51 32 RR(C)5																										
SUITABLE FOR	DIN:	-		W.Nr.:																								
	Unalloyed steels:	St 33 to St 52.3		1.0035 to 1.0570																								
	Boiler plates:	HI, HII, 17 Mn4		1.0345, 1.0425, 1.0481																								
	Pipe steels:	St 35 to St 52.4		1.0308 to 1.0581																								
	-	StE 210.7 to StE 360.7		1.0307 to 1.0582																								
	Shipbuilding plates:	A, B, D		1.0440, 1.0472, 1.0475																								
	Steel castings:	GS-38 to GS-52		1.0416 to 1.0551																								
	Thin sheets:	1623/1																										
APPROVALS	CE approved																											
WELDING POSITIONS:																												
ALL WELD METAL ANALYSIS	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td><0,03</td> <td>0.5</td> <td>0,35</td> <td><0.025</td> <td><0.025</td> </tr> </tbody> </table>					C	Mn	Si	P	S	<0,03	0.5	0,35	<0.025	<0.025													
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