

# S-76LTH

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E7016-G  
JIS Z3211 E4916-N1 AP L  
EN ISO 2560-A E42 6 Z B H5

SMW

## Applications

S-76LTH is extra low hydrogen type covered electrode. It can be used for welding of high tensile steel and low temperatures applications such as off-shore structure, LPG storage tank and carrier.

## Characteristics on Usage

Deposited weld metal is Ni, Ti, B type and better notch toughness down to -60°C(-76°F) and CTOD properties at -40°C(-40°F) temperature. Its usability is good with AC/DC+ applications and very low hydrogen electrode.

## Notes on Usage

- ① Dry the electrodes at 350~400 °C(662~752°F) for 60 minutes before use.
- ② Keep the arc as short as possible, and avoid large width of weaving.
- ③ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.

## Welding Position

## Current



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

AC or DC +

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

C	Si	Mn	P	S	Ni	Ti	B
0.08	0.35	1.35	0.013	0.004	0.45	0.018	0.0015

## 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)
540 (78,400)	590 (85,600)	30.0	-46 (-51) -60 (-76)	190 (137) 100 (72)

## Approval

## I Packing

ABS, DNV

Packet	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg (44 lbs)
Vacuum Pack	1.5 kg (3.3 lbs)
Carton	1.5 kg (3.3 lbs) × 10 : 15kg (33 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size 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