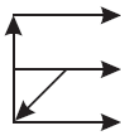


LEZOZS-18	AWS:7015 DIN1913-E5100B10 EN499:E46AB22H10
------------------	--

MAIN PURPOSE

LEZOZS-18 electrodes are intended for manual arc welding of important corrosion-resistant steel constructions (10HSND, 15HSND, 10HNDP and other similar steels). Welding possible in all spatial positions, except vertical top-down, with direct current of reverse polarity.

**Recommended current (A)**

Diameter, mm	Welding position		
	Lower pos.	Vertical pos.	Ceiling pos.
3,0	90-110	70-90	60-90
4,0	150-170	130-140	120-130
5,0	170-190	150-170	-

Electrode welding characteristics:

Welding rate, g/Ah:	9,5
Consumption of electrodes (on 1 kg of welded metal), Kg.:	1,5

Main characteristics of seam and welded metal**Mechanical properties of seam metal, not less than:**

Ultimate stress, MPa	490
Specific elongation, %	22
Impact strength, J/cm ²	140

Chemical composition of welded metal, %

Carbon, no more than	0,11
Manganese, no more than	1,00
Silicon	0,15-0,45
Nickel	0,20-0,45
Chrome	0,70-1,30
Copper	0,20-0,50
Sulfur, no more than	0,030
Phosphorus, no more than	0,035