

S-86LTH

Type : Basic

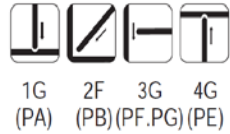
Conformances

AWS A5.5/SAME SFA5.5 E8016-G

Applications

- ▶ Low temperature strength steel
- ▶ Offshore structure
- ▶ LPG, LNG storage tank

Applications



Features

- ▶ Extra low hydrogen electrode (HDM ≤ 5ml/100g)
- ▶ Good impact value at -60°C

Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X 1hr

Diameter / Packaging

Diameter	Length	standard		Vacuum				Steel can	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	4.5kg(9.9lbs)	18kg(40lbs)
2.6 (3/32)	350 (14)			✓		✓		✓	
3.2 (1/8)	350 (14)			✓		✓		✓	
4.0 (5/32)	400 (16)			✓		✓		✓	
5.0 (3/16)	400 (16)			✓		✓		✓	

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Typical Chemical Composition (%)

C	Si	Mn	P	S	Ni	Ti	B
0.05	0.29	1.49	0.010	0.002	0.91	0.022	0.003

Typical Mechanical Properties of All-Weld Metal

Condition	YS	TS	EL	Temp	CVN-Impact Value
	Mpa(lbs/in)	Mpa(lbs/in)	(%)	°C (°F)	J (ft·lbs)
AW	532 (77,200)	504 (87,600)	29.6	-45 (-51)	130 (96)
				-60 (-76)	105 (77)

Typical Operating Procedures

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)
F	60~90	90~140	130~190	180~240
V-up, OH	50~50	80~120	120~170	150~200