Hydrogen Controlled Electrodes | Gemini LD52U

Key Facts

- Double Flux Coated electrode using the twin coat extrusion process, which literally combines two flux coatings into one.
- The 1st coating (the inner) delivers a smooth running weld with fine ripple shape, low spatter levels and excellent bead shape and edge wash.
- The 2nd coating (the outer) provides the bite for penetration and the hydrogen controlled deposit requirements of the electrode.
- The **U** stands for under-bead penetration. LD52U is an excellent root run electrode and provides superb one-sided full peno root runs in butt welds.

Description

Hydrogen controlled, double coated electrode recommended for welding unalloyed and low alloyed steels of the medium tensile class. This electrode has an extremely stable arc and is not affected by rust or paint on the work surface. Vertical up welding is outstanding with the weld metal being easy to direct & control ensuring the highest quality weld deposits with no undercut (operator dependant).

Classification

AWS A5.1: E7016

Welding Positions

Flat, horizontal, vertical-up and overhead.

Markings & Identification

End tip Colour: Grey
End side Colour: Red
Printing: E 7016

Applications

Suitable for root passes and all-positional welding. Applications include one sided weld joints on steel fabrications, bridges, ship building, equipment repair and maintenance work. Not recommended for higher-strength steels.



Typical All Weld Metal Analysis

Carbon	Manganese	Silicon
0.05%	0.80%	0.60%
Nickel	**Chromium**	**Molybdenum**
< 0.02%	<0.06%	< 0.02%
Vanadium	**Phosphorus**	**Sulphur**
< 0.02%	< 0.10%	< 0.05%

Typical All Weld Metal Mechanical Properties

Yield Strength:	430 MPa
Tensile Strength:	500 MPa
Elongation (5xD):	28%
Reduction of Area:	70%
Impact Strengths ISO-V	150J @ 0°C 80J @ -20°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	5kg	20kg	40-60	100035
2.6mm	6 Sticks		40-60	100035H
3.2mm	5kg	20kg	90-130	100036
3.2mm	6 Sticks		90-130	100036H
4.0mm	5kg	20kg	120-160	100037

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.