



CEWELD AquaForce LC

TYPE CEWELD® AquaForce LC is a wet underwater welding electrode with extreme low C-content.(Type E 7016)

APPLICATIONS Welding standard ship steel grades A, B & D in submerged condition according the requirements of AWS D3.6M. Developed for joining under water objects, plate doubling in ship repair, sealing sheet, pile profiles etc. All applications underwater for carbon steels up to 420 MPa and down to -20 °C for AV. Tested up to a water depth of 20m

PROPERTIES CEWELD® AquaForce LC is the first Basic electrode that was developed with "Hydrophobic sand" to offer maximum moisture resistance. CEWELD® AquaForce LC is characterized by its superior ability to produce flat (non-concave) welds with deeper penetration in all positions including PB, PC, PD, PE and PG position. The special (Armcore) ultra low carbon core wire of this electrode reduces the hardness from 195 HV to 165 HV hardness in the pure weld metal caused by the high cooling rate (T8/5) when welding under water. CEWELD® AquaForce LC has a unique Basic coating reduce the Oxygen content in the weldmetal to obtain better ductility than can be achieved with standard wet welding rutile electrodes.

CLASSIFICATION

AWS	A 5.1: E 7016
AWS	A 5.35: UWE 7014 3A
DIN	2302 E 42 2 Z RB 10 fr (PA,PB,PC,PD,PE,PG)

SUITABLE FOR **Reh ≤420 MPa (60 ksi) ISO 15608: 1.1, 1.2**
 1.0035, 1.0570, 1.0461,1.0562, 1.4620,1.0565, 1.0345, 1.0425, 1.0481, 1.0308 to 1.0581, 1.0307, 1.0582, 1.0440, 1.0472, 1.0475, 1.0476, 1.0416, 1.0551
 S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240
 ASTM: A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 678 Gr. A, B; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S
	0.05	0.2	0.45	0.025	0.025

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V	
	As Welded /	MPa	MPa	(%)	0°C	-20°C
		460	580		45	35

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175



CEWELD AquaForce LC

AQUAFORCE LC 3,2 X
350MM

Type	KG/unit	EANCode
Can	2,8	8720663400017

AQUAFORCE LC 4,0 X
350MM

Type	KG/unit	EANCode
Can	2,8	8720663400024