

COVERED ELECTRODES FOR MILD STEEL

DESCRIPTION & APPLICATIONS :

- SC-10 is a high cellulose all-positional electrode type.
- Designed for deep penetration on root and filler layers of butt or fillet welding. It has stable arc, fast congealing weld and good slag removability.
- It is used for welding mild steel in pipeline, pressure vessels, storage tank and outdoor welding.

NOTE ON USAGE :

- Keep away heat and high humid ambient. Rebake the electrodes at 70~80°C for 30~60 minutes prior to use.
- Recommended with low current welding, when moving range of the electrodes should be controlled within 2.5 times of the electrode's diameter while welding with weave method.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.12	0.48	0.2	0.014	0.007

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
425(43.4)	495(50.5)	28	36(3.7)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350	350
Amp.	F	80-120	110-170	150-200
	V & OH	70-110	90-150	-