

ELECTROSLAG WELDING FOR $\geq 550\text{N/mm}^2$ GRADE HIGH TENSILE STRENGTH STEEL

DESCRIPTION & APPLICATIONS :

- SF-60 x SWE-60G is designed for electroslag welding.
- It's combination of melting flux and low alloy steel wire with special alloy.
- With special alloy elements, the cell will be shrunk and the toughness of the bead will increased.
- Suitable for the welding of high efficiency and vertical thick steel plate of 550N/mm² grade high tensile strength steel.
- Suitable for welding of shipbuilding, steel structure, and bridge. Especially for the box column of SC.

NOTE ON USAGE :

- The precision of the assembly's gap should be under 0.5mm. Keep the position of spot welding at the outer side.
- Remove any bump, oil, and moisture before welding.
- The wire-stick-out should be 30~40mm.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P	S	Special elements
0.12	1.52	0.14	0.012	0.008	properly

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -30 ° C J(Kgf-m)
545(55.6)	637(65.0)	27	43(4.4)