SL-108M

AWS A5.5 E10018-M
EN ISO 18275-A E 62 5 1.5NiMo B 3 2
GB T5118 E7018-M

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-108M is an iron powder low hydrogen electrode designed for welding 690N/mm² grade high tensile steel.
- It can obtain good heat resistance and great crack resistance because of its low hydrogen composition in the weld metal.
- In addition to the welding before hardfacing.

NOTE ON USAGE :

- Rebake the electrodes at 300 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Backstep is the welding method to prevent blowholes during the arc starting.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.06	1.12	0.32	0.012	0.005	1.98	0.01	0.36

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm²(Kgf/mm²)	TENSILE STRENGTH N/mm²(Kgf/mm²)	ELONGATION RATE %	IMPACT VALUES -51 °C J(Kgf-m)
638(65.1)	725(73.9)	22	60(6.1)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Current (Amp)	F	90-130	130-180	180-240
	V & OH	80-120	110-160	–