

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-118M is an iron power low hydrogen electrode designed for welding 780N/mm² grade high tensile steel.
- It can obtain good heat resistance and excellent mechanical properties.
- It is suitable for the welding of WEL TEN-80 high tensile steel as well.

NOTE ON USAGE :

- Re bake 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	1.51	0.42	0.010	0.009	1.98	0.03	0.38

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 -51 °C J(Kgf-m)
695(70.9)	785(80.1)	23	58(5.9)

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	-