

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-120 is a low hydrogen electrode for the welding of 830N/mm² grade high tensile steel.
- It is used for heat treatable low alloy steels, such as SCM21/4 chrome-molybdenum steel, SNCM8 Ni-Cr-Mo steel, high tensile steels such as WEL-TEN80/80C/80P/80E, ASTM A486 Gr120/A508 Gr5a.4a/A543 GrB3.C, etc.

NOTE ON USAGE :

- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Take the backstep method to prevent blowholes at the arc starting.
- Preheating base metals at 150-200°C.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.06	1.60	0.80	0.012	0.004	2.58	0.15	0.52

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 -20 °C J(Kgf-m)
810(82.7)	900(91.8)	20	54(5.5)

SIZE AND RECOMMENDED CURRENT RANGE : AC or 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	-