

COVERED ELECTRODES FOR 490N/mm² HIGH TENSIL STEEL

DESCRIPTION & APPLICATIONS :

- SL-24 is an iron powder electrode developed especially for flat, fillet and gravity welding.
- Less spatter, high deposition rate as well as 160%. It is used for single pass of fillet welding on H-beam and T-beam.

NOTE ON USAGE :

- Rebake the electrodes at 200°C for 60 minutes before use.
- Recommended use appropriate long size for semi-auto gravity welding.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.09	0.75	0.33	0.018	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -20 °C J(Kgf-m)
500(51.0)	570(58.2)	24	30(3.1)

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	550
Amp.	Flat & H-Fillet	130-170	160-200	220-260