

## COVERED ELECTRODES FOR 490N/mm<sup>2</sup> HIGH TENSIL STEEL

### DESCRIPTION & APPLICATIONS :

- SL-50 is a low hydrogen electrode designed for 490N/mm<sup>2</sup> grade high tensile steel. Suitable for low alloy steels, medium-high carbon steels, heavy steel plates, cast steels.
- The welding can be done with stable arc and good X-Ray soundness. It is suitable for ship buildings, bridge and steel structures segments.

### NOTE ON USAGE :

- Rebake the electrodes at 300~350°C for 1hr and keep at 100~150°C before daily use.
- Take the backstep method to prevent blowholes at the arc starting.
- Keep the arc as short as possible.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.08	1.00	0.45	0.016	0.009

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	EL %	IV -30 °C J(Kgf-m)
496(51)	564(58)	28	90(9.2)

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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400/450	400/450
Amp.	F	90-130	130-180	180-240
	V & OH	90-120	110-160	160-200