

COVERED ELECTRODES FOR 490N/mm² HIGH TENSIL STEEL

DESCRIPTION & APPLICATIONS :

- SL-50DR is a low hydrogen type electrode for welding 490N/mm² grade high tensile steel.
- Stable arc, less spatter, nice welding bead and slag removable easily. It is used for vehicle and general steel structure segments.

NOTE ON USAGE :

- Rebake the electrode at 80~100°C for 30~60 minutes prior to use.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.08	0.40	0.27	0.014	0.007

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
481(49)	554(56.5)	24	40(4.1)

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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amp.	F	100-140	140-180	180-240
	V & OH	70-110	100-160	140-200