

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

### DESCRIPTION & APPLICATIONS :

- SL-58M is an all-position iron powder low hydrogen electrode specially formulated to meet more stringent requirements of military specification MIL-E-0022200/10 for mechanical properties.
- Suitable for steel structures, storage tank, power plant and petroleum chemical industry.

### NOTE ON USAGE :

- Rebake the electrodes at 300~350°C for 60 minutes before use.
- Take the backstep method to prevent blowholes at the arc starting.

### WELDING POSITION :



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

| C    | Mn   | Si   | P     | S     |
|------|------|------|-------|-------|
| 0.09 | 1.32 | 0.40 | 0.010 | 0.008 |

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

| YP<br>N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> ) | TS<br>N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> ) | EL<br>% | IV -30 °C<br>J(Kgf-m) |
|------------------------------------------------|------------------------------------------------|---------|-----------------------|
| 495(50.5)                                      | 565(57.7)                                      | 30      | 92(9.4)               |

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

| Diameter (mm) |        | 3.2    | 4.0     | 5.0     |
|---------------|--------|--------|---------|---------|
| Length (mm)   |        | 350    | 350     | 350     |
| Amp.          | F      | 90-130 | 130-180 | 180-220 |
|               | V & OH | 80-120 | 110-150 | -       |