

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-60 is a low hydrogen electrode for the welding of 550N/mm² grade high tensile steel.
- This electrode is suitable for forging, structural steel, alloy steel, high pressure pipe, pressure vessel, ASTM A299/302/372, etc.

NOTE ON USAGE :

- Prebake the base metal at 100~150°C.
- 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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.081	1.27	0.39	0.021	0.008

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 -30 °C J(Kgf-m)
539(55)	637(65)	29	80(8.2)

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	150-200