

## ≥ 550N/mm<sup>2</sup> High tensile steel SMAW

### DESCRIPTION & APPLICATIONS :

- SL-63 is electrodes designed for 550N/mm<sup>2</sup> grade high tensile steel application. Thin plate to middle thickness plate joining is typically recommended especially for horizontal welding.
- Superior weldability with high deposition rate but less spatters. Stable arc transfer and smooth slag removal, good for all positional welding and nice bead appearance.
- It is good for steel fabrication i.e. mobile, bridges, constructions.

### NOTE ON USAGE :

- If the consumable expose to the air more than 4 hours, rebake the electrodes at 80~100°C for 30~60 minutes before welding.

### WELDING POSITION :



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

C	Mn	Si	P	S	Cu
0.08	0.62	0.32	0.016	0.007	0.32

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TENSILE STRENGTH N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	ELONGATION RATE %
482(49.2)	570(58.1)	25

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

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