

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-80 is a low hydrogen electrode for the welding of 620N/mm² grade high tensile steel.
- It is suitable for shipbuilding, machine fabrication, offshore structure, pressure vessel, high pressure pipe.

NOTE ON USAGE :

- Preheating base metals at 100 ~ 150°C.
- Rebake the electrodes at 300 ~ 350°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	Ni	Mo
0.08	1.15	0.43	0.018	0.004	0.77	0.30

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)
620(63.3)	705(72)	24	78(8.0)

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