

## COVERED ELECTRODES FOR MILD STEEL

### DESCRIPTION & APPLICATIONS :

- SM-26 is a iron power, titania and high titanium sodium electrode.
- Designed for all-positional welding. The welding can be done with high deposition rate, excellent anti-crack. Suitable for thin and medium thickness base metal or fillet welding.
- With stable arc, less spatter, as well as the good bead appearance and slag removability.
- It is used for ship building, vehicle, bridge and steel structures, etc.

### NOTE ON USAGE :

- Rebake the electrodes at 80~100°C for 30~60 minutes prior to use.
- Proper welding current is recommended for getting good X-Ray soundness and mechanical properties.

### WELDING POSITION :



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

C	Mn	Si	P	S
0.06	0.35	0.17	0.018	0.009

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	EL %	IV 0°C J(Kgf-m)
422(43.1)	483(49.3)	29	81(8.3)

### 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