

LOW TEMPERATURE-SERVICE LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SN-86G is a low hydrogen electrode for low temperature service low alloy steel.
- For all welding positions. With good impact performance down to -45°C and good mechanical properties.
- Suitable for welding of 1.5%Ni steel or LPG tanks.

NOTE ON USAGE :

- Proper preheat at 100~150°C.
- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Keep the arc as short as possible. Please take the method of back-forward.
- Set up current in a recommended range to obtain impact value.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni
0.06	0.86	0.40	0.013	0.004	2.00

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 -45 °C J(Kgf-m)
540(55.1)	630(64.3)	26	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	100-140	140-180	180-210
	V & OH	90-120	120-160	-