SN-88C2

AWS A5.5 E8018-C2
EN ISO 2560-A E 46 6 3Ni B 3 2
GB T5118 E5518-C2

LOW TEMPERATURE-SERVICE LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SN-88C2 is an iron powder low hydrogen electrode for low temperature service low alloy steel.
- It has excellent deposition efficiency and mechanic properties, also excellent impact value down to -75°C.
- Suitable for welding of 3.5%Ni steel or LPG tanks.

NOTE ON USAGE :

- Proper preheat at 100~150°C and PWHT at 600~630°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
0.07	0.9	0.56	0.018	0.005	3.40

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 -75°C J(Kgf-m)	HEAT TREATMENT
550(56.1)	625(63.8)	23	51(5.2)	605°Cx1hr

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	-