

## LOW TEMPERATURE-SERVICE LOW-ALLOY STEEL SMAW

### DESCRIPTION & APPLICATIONS :

- SN-98G is an iron powder low hydrogen electrode designed for welding of 620N/mm<sup>2</sup> grade low temperature service low alloy steel.
- Its coating contains iron powder to increase working efficiency and deposition efficiency. For all welding positions. With good impact performance down to -45°C and good mechanical properties.
- Suitable for welding of LPG tanks or aluminum killer steel for low temperature.

### 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	Mo
0.07	1.50	0.49	0.016	0.004	0.90	0.28

### 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 %	IMPACT VALUES -45 °C J(Kgf-m)
584(59.6)	710(72.4)	26	52(5.3)

### 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	-