

≥ 550N/mm² High tensile steel SMAW

DESCRIPTION & APPLICATIONS :

- SL-110 is a low hydrogen electrode designed for welding 690N/mm² grade high tensile steel.
- It can obtain good heat resistance and excellent mechanical properties in all position because of its low hydrogen composition.

NOTE ON USAGE :

- Rebake the electrodes at 300 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Backstep is the welding method to prevent blowholes during the arc starting.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.08	1.5	0.25	0.016	0.008	2.2	0.32	0.5

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 -20 °C J(Kgf-m)
740(75.5)	870(88.8)	21	56(5.7)

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	-