

## COVERED ELECTRODES FOR 490N/mm<sup>2</sup> HIGH TENSIL STEEL

### DESCRIPTION & APPLICATIONS :

- SL-50D is an iron powder low hydrogen electrode developed especially for vertical down stick welding.
- It is suitable for the ship buildings, bridge and steel structures segments.

### NOTE ON USAGE :

- Rebake the electrodes at 300~350°C for 30-60 minutes and keep 100~150°C before daily use.
- When vertical down welding must be maintained with the angle of electrode: 40-85 degrees. DO NOT take weaving motion method.

### WELDING POSITION :



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

C	Mn	Si	P	S
0.09	0.86	0.40	0.016	0.005

### 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 -30 °C J(Kgf-m)
490(50.0)	560(57.1)	29	62(6.3)

### SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amp.	Vertical Down	110-160	140-210	220-270