

COVERED ELECTRODES FOR 490N/mm² HIGH TENSIL STEEL

DESCRIPTION & APPLICATIONS :

- SL-56 is an iron powder low hydrogen and 490N/mm² high tensile steel electrode. Suitable for flat, H-fillet and gravity welding.
- With high deposition rate as well as 127%. A premium, multiple deoxidized, could be weld on rust or dirt steel surface. It is suitable for welding in ship building, bridges and vehicle segments.

NOTE ON USAGE :

- Dry the electrode at 200~250°C for 30~60 minutes before use.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.09	1.22	0.21	0.026	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -20 °C J(Kgf-m)
518(52.9)	570(58.2)	25	48(4.9)

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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	550
Amp.	F & H-Fillet	120-160	160-200	200-240