SL-58

AWS A5.1 E7018
EN ISO 2560-A E 42 3 B 3 2
GB T5117 E5018

COVERED ELECTRODES FOR 490N/mm^2 HIGH TENSIL STEEL

DESCRIPTION & APPLICATIONS :

- SL-58 is an iron powder low hydrogen electrode for the welding 490N/mm^2 grade high.
- It is especially suitable for steel structures, petroleum chemical industry, power plants and storage tank.

NOTE ON USAGE :

- Rebake the electrodes at 300~350°C for60 minutes and keep at 100~150°C before daily use.
- Take the backstep method to prevent blowholes at the arc starting.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.07	1.20	0.47	0.016	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm^2(Kgf/mm^2)	TS N/mm^2(Kgf/mm^2)	EL %	IV -30°C/-40°C J(Kgf-m)
518(52.9)	604(61.6)	28	80(8.2)/58(5.9)

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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Amp.	F	90-130	130-180	180-240
	V & OH	80-120	110-160	–