

COVERED ELECTRODES FOR 490N/mm² HIGH TENSIL STEEL

DESCRIPTION & APPLICATIONS :

- SLH-58 is an iron powder low diffusible hydrogen electrodes. With excellent mechanical properties and impact toughness at low temperature (-45°C)
- It is suitable for steel structure, storage tank, power plant and petroleum chemical industry.

NOTE ON USAGE :

- Rebake electrodes at 300~350°C for 60 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
0.062	1.25	0.49	0.018	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -45 °C J(Kgf-m)
525(53.6)	585(59.7)	29	80(8.2)

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	180-220
	V & OH	80-120	110-160	-