

COVERED ELECTRODES FOR MILD STEEL

DESCRIPTION & APPLICATIONS :

- SM-10 is an ilmenite type electrode can be used for all-positional welding.
- The excellent X-Ray soundness and mechanical properties, as well as the good bead appearance and less spatter can be observed. Less spatter , stable arc and provides easy weld pool control.
- It is used for ship body, vehicle frames, oil tank and steel structures.

NOTE ON USAGE :

- Proper welding current is recommended to get good X-Ray soundness.
- Clean up the base metal to be free from contamination. Rebake the electrodes at 80~100°C for 30~60 minutes prior to use.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.07	0.46	0.11	0.021	0.008

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)
424(43.3)	467(47.7)	27	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.	F	80-130	130-180	170-240
	V & OH	60-120	110-160	140-200