# SN-88C1

AWS A5.5 E8018-C1
EN ISO 2560-A E 46 6 2Ni B 3 2
GB T5118 E5518-C1

## LOW TEMPERATURE-SERVICE LOW-ALLOY STEEL SMAW

### DESCRIPTION & APPLICATIONS :

- SR-88C1 is an iron low hydrogen electrode for low temperature service low alloy steel.
- Its coating contains iron power to increase working efficiency. For all welding positions. With good impact performance down to -60°C and good mechanical properties.
- Suitable for low temperature machine, welding of aluminum killer steel and 2.5%Ni steel. For instance ASME SA203Gr.A or B.

### NOTE ON USAGE :

- Proper preheat at 100~150°C and PWHT at 600~630°C.
- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Keep the arc as short as possible. Please take the method of back-forward.
- Set up current in a recommended range to obtain impact value.

### WELDING POSITION :

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

| C | Mn | Si | P | S | Ni |
|---|---|---|---|---|---|
| 0.06 | 0.70 | 0.35 | 0.014 | 0.007 | 2.23 |

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

| YIELD POINT $N/mm^2(Kgf/mm^2)$ | TENSILE STRENGTH $N/mm^2(Kgf/mm^2)$ | ELONGATION RATE % | IMPACT VALUES -60°C J(Kgf-m) | HEAT TREATMENT |
|---|---|---|---|---|
| 526(53.7) | 596(60.8) | 27 | 61(6.2) | 605°Cx1hr |

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

| Diameter (mm) | | 3.2 | 4.0 | 5.0 |
|---|---|---|---|---|
| Length (mm) | | 350 | 400 | 400 |
| Current (Amp) | F | 100-140 | 140-180 | 180-210 |
| | V & OH | 90-120 | 120-160 | - |