

ATMOSPHERIC CORROSION RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SN-78W1 is an iron powder low hydrogen electrode designed for welding of atmospheric corrosion resistant steel.
- This electrode has resistibility to the atmospheric corrosion, and good crack resistance in all positions welding. The weld metal of SW-78W1 consists of Cu and Ni which has good corrosion resistance.
- Suitable for 490N/mm² corrosion resistant steel, like bridges, constructions, and cars.

NOTE ON USAGE :

- Proper preheat at 80~100°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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Cu
0.06	0.62	0.50	0.016	0.006	0.33	0.19	0.46

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 -20 °C J(Kgf-m)
517(52.8)	582(59.4)	28	120(12.2)

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	-