

SMAW Electrodes

GL5218

AWS A5.1M E4918 / A5.1 E7018
JIS Z 3211 E4918UH10
ISO 2560-A-E 46 3 B

Product Features:

- Iron powder low hydrogen type covered electrode for high tensile strength steel.
- Good for RT examination, good mechanical properties and good crack resistance.
- High welding performance, low spatter loss and easy slag removal.
- Good manipulation in vertical position.

Applications:

- Suitable for welding of 490 N/mm² high tensile strength low alloy steel structures on shipbuilding, buildings, bridges, machinery, heavy thickness steel castings and pressure vessels.
- Suitable for welding of moderate & high carbon contained steels.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.09	0.50	1.24	0.021	0.006	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value	
			(-20°C) J	(-30°C) J
574	633	28	117	84

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	80~110	100~140	150~200	190~230	260~310
Vertical / overhead position	75~105	90~130	120~150	140~170	----

Note:

- 300~350°C x 1 hr baking prior to use.

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw