

SMAW Electrodes

GL5218-1

AWS A5.1M E4918-1 / A5.1 E7018-1
JIS Z 3211 E4918-1UH5
ISO 2560-A-E 42 5 B H5

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.
- Improved weld metal to have lower transition temperature than conventional E7018 electrode.

Applications:

- Welding of 500 N/mm² high tensile strength steels for LPG tankers, LPG storage tanks, bridges, pressure vessels and low temperature service structure.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.06	0.22	1.27	0.019	0.007	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value	
			(-45°C) J	(-50°C) J
505	576	27	115	91

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

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

Note:

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

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