

# SMAW Electrodes

## GL5226

AWS A5.1M E4928 / A5.1 E7028  
JIS Z 3211 E4928UH15

### Product Features:

- Iron powder contained available for high deposition efficiency.
- Good bead appearance.
- Good re-arcing property and manipulation.
- Suitable for gravity semi auto welding, easy slag removal.
- Available for high current welding.

### Applications:

- Suitable for horizontal fillet position of Build-up type steel beam and girder fabrication such as H beam or T bar.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.06	0.34	0.90	0.019	0.006	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
441	516	26	58

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

Diameter / Length	4.0/450	5.0/550/700	5.5/550/700	6.0/550/700
Flat position	160~200	250~280	260~320	300~360

### Note:

- 100~150°C x 1 hr baking prior to use.

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