

SMAW Electrodes

EX55V

AWS A5.1M E4948 / A5.1 E7048
JIS Z 3211 E4948H10
ISO 2560-A-E 42 3 B

Product Features:

- Low hydrogen type covered electrode for high tensile strength steel special in vertical downward position.
- Easy slag removal and good manipulation.
- Good bead appearance.
- Good mechanical and crack resistance properties.

Applications:

- Suitable for vertical downward steel structures on shipbuilding, bridge, steel structure and pressure vessels.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.09	0.42	0.82	0.016	0.007	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
442	533	32	112	102

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

Diameter / Length	3.2/350	4.0/400/450	5.0/450
Vertical / overhead position	120~150	160~200	200~250

Note:

- 300~350°C x 1 hr baking prior to use.
- Keep arc length as short as possible.

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