

SMAW Electrodes

GL60

AWS A5.5M E6216-G / A5.5 E9016-G
JIS Z 3211 E6216-3M2UH10
ISO 18275-A-E 62 2 MnMo B

Product Features:

- Low hydrogen type covered electrode for 620 N/mm² grade high tensile strength steel.
- Suitable for all positions.
- Good for RT examination, good mechanical properties.
- Low hydrogen content in weld metal, good crack resistance.

Applications:

- Suitable for welding of 620 N/mm² high tensile strength steel main structures on buildings and pressure vessels.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Mo	Fe
0.07	0.40	1.43	0.018	0.004	0.31	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
629	697	28	143

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

Diameter / Length	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	100~140	150~190	190~240	240~300
Vertical / overhead position	80~110	120~160	150~180	----

Note:

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

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