

SMAW Electrodes

GL70

AWS A5.5M E6916-G / A5.5 E10016-G
JIS Z 3211 E6916-N4M3 (Similar)
ISO 18275-A-E 62 Z 1NiMo B

Product Features:

- Low hydrogen type covered electrode for 690 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 690 N/mm² high tensile strength steel structures on pressure vessels and steel constructions.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Mo	Fe
0.06	0.38	0.88	0.96	0.46	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
655	721	25

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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