

# SMAW Electrodes

## GL80

AWS A5.5M E7616-G / A5.5 E11016-G  
JIS Z 3211 E7816-N4CM2  
ISO 18275-A-E 69 Z Mn2NiMo B

### Product Features:

- Low hydrogen type covered electrode for 760 N/mm<sup>2</sup> 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 760 N/mm<sup>2</sup> high tensile strength steel structures on pressure vessels and steel constructions.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.07	0.63	1.66	1.92	0.28	0.39	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
834	878	22

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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