

SMAW Electrodes

GL100

AWS A5.5M E8316-G / A5.5 E12016-G
JIS Z 3211 E8318-N4C2M2 (Similar)
ISO 18275-A-E 79 Z Z B

Product Features:

- Low hydrogen type covered electrode for 830 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 830 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	Cr	Mo	Fe
0.07	0.32	1.71	2.29	1.16	0.44	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
1014	1042	15

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

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450
Flat position	70~100	100~140	150~190	190~240
Vertical / overhead position	60~90	80~110	120~160	150~180

Note:

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

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