

SMAW Electrodes

- High Tensile & High Yield Strength Steel

GL128M

AWS A5.5M E8318M / A5.5 E12018M
JIS Z 3211 E8318-N4C2M2
ISO 18275-A-E 69 5 Mn2NiMo B

Product Features:

- Iron powder low hydrogen type covered electrode for low alloy high yield and high tensile strength steel.
- Good arc stability, less spatter loss and suitable for all positions.
- Good for RT examination, good mechanical properties.
- Low moisture absorption type covered flux to get good crack resistance.

Applications:

- Suitable for welding of 830 N/mm² grade low alloy steels or similar grade steels on pressure vessels and general steel structures.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.06	0.16	1.67	0.44	2.13	0.46	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-50°C) J
817	841	20	69

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

Diameter / Length	3.2/350	4.0/400	5.0/450
Flat position	90~140	150~200	220~270
Vertical / overhead position	80~110	120~150	-

Note:

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

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