

# SMAW Electrodes

## GL52

AWS A5.1M E4916 / A5.1 E7016  
JIS Z 3211 E4916UH10  
ISO 2560-A-E 42 3 B

### Product Features:

- Low hydrogen type covered electrode for high tensile strength steel.
- Suitable for all positions.
- Good for RT examination, good mechanical properties.
- Basic type slag, easy to remove.

### Applications:

- Suitable for welding of 490 N/mm<sup>2</sup> high tensile strength low alloy steel structures on shipbuilding, buildings, bridges, machinery, heavy thickness steel castings and pressure vessels.
- Suitable for welding of moderate & high carbon contained steels.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.07	0.49	1.02	0.015	0.004	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value	
			(-20°C) J	(-30°C) J
486	571	33	169	167

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

Diameter / Length	2.6/300	3.2/350	4.0/350/400	5.0/450	6.0/450
Flat position	70~100	100~150	150~190	190~230	240~320
Vertical / overhead position	60~90	80~110	120~160	140~180	----

### Note:

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

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