

SMAW Electrodes

For Chromium-Molybdenum Low Alloy Steels

GL76A1 / GL78A1

AWS A5.5M E4916(8)-A1
A5.5 E7016(8)-A1
JIS Z 3223 E4916(8)-1M3

Product Features:

- Low hydrogen / iron powder low hydrogen type covered electrode for low alloy heat resistant steel.
- Approximately 0.5% Mo element contained in all deposited weld metal.
- Good for RT examination, good mechanical properties.
- Low hydrogen contained in weld metal to get good crack resistance.

Applications:

- Suitable for welding of 0.5% Mo grade heat resistant steel, cast steel such as A335-P1, A336-F1.

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

C	Si	Mn	Mo
0.07	0.43	0.75	0.57

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT) °C × 1hr
642	694	29	620

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	60~90	100~140	150~190	220~270
Vertical / overhead position	50~80	80~110	120~150	-

Note:

- 300~350°C x 1hr baking prior to use.
- The welding current for iron powder type can be available to increase 10~20 ampere.

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-233213
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www.goodweld.com.tw