

SMAW Electrodes

for Chromium-Molybdenum Low Alloy Steels

GL86B2 / GL88B2

AWS A5.5M E5516(8)-B2
A5.5 E8016(8)-B2
JIS Z 3223 E5516(8)-1CM

Product Features:

- Low hydrogen/ iron powder low hydrogen type covered electrode for low alloy heat resistant steel.
- Very low hydrogen contained in weld metal.
- All deposited weld metal contains approximately 1.1%Cr- 0.5%Mo alloy elements, good for serving temperature $\leq 550^{\circ}\text{C}$.
- Good for RT examination, good mechanical properties.

Applications:

- Suitable for welding of 1.25% Cr-0.5% Mo grade steel such as A387-Gr.12 C1.1&2; A335-Gr.11&12.

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

C	Si	Mn	Cr	Mo
0.08	0.55	0.81	1.13	0.51

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
640	710	26	690

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	90~140	150~180	220~270
Vertical / overhead position	50~80	80~120	120~150	--

Note:

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

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