

# SMAW Electrodes

## GL55Ni

AWS A5.5 E8018-G / A5.5M E5518-G  
ISO 2560-A-505B  
JIS Z 3211 E5518-G

### Product Features:

- GL55Ni is an iron powder low hydrogen type electrode for all positions with excellent mechanical properties and crack resistance.
- Deposited metal contains approximately 1.5%Ni, providing high notch toughness as low temperature (-50°C).

### Applications:

- Suitable for welding of low temperature service steels (ASTM A537 CLASS 2,A516).

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Ni
0.07	0.58	1.05	0.016	0.008	1.55

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-50°C) J
491	592	30	87

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	150~200	190~240
Vertical /overhead position	60~90	80~110	120~150	140~190

### Note:

- Electrode should be redried at 350~400°C for 60 minutes before use.
- Keep the arc as short as possible.
- Welding with excessively high input should be avoided to assure strength and toughness of weld.

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