

SMAW Electrodes for Weathering Steel

GL78W1

AWS A5.5M E4918-W1 / A5.5 E7018-W1
JIS Z 3214 E4918-NCC2 U
ISO 2560-A-E 46 2 B

Product Features:

- Iron powder low hydrogen type covered electrode for 490 N/mm² grade high tensile strength low alloy weathering steel.
- Weld metal contains Ni, Cr, Cu elements, good for weathering resistance.
- Good for RT examination, good mechanical properties.

Applications:

- Suitable for welding of high tensile strength weathering steels such as COR-TEN 50A, 50B and COR-TEN or SMA 50.

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

C	Si	Mn	Cr	Ni	Cu
0.06	0.48	0.47	0.24	0.26	0.40

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
505	575	28	118

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	90~140	150~200	220~270
Vertical / overhead position	60~90	80~110	120~150	--

Note:

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

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