

# SMAW Electrodes for Weathering Steel

## GL88W2

AWS A5.5M E5518-W2 / A5.5 E8018-W2  
JIS Z 3214 E5716-NCC1 U  
ISO 2560-A-E 50 2 B

### Product Features:

- Iron powder low hydrogen type covered electrode for 550 N/mm<sup>2</sup> 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 550 N/mm<sup>2</sup> weathering steels such as COR-TEN 60 or SMA 58.

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

C	Si	Mn	Cr	Ni	Cu
0.06	0.49	0.70	0.51	0.55	0.51

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
570	660	25	102

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.

Goodweld Corporation  
No.99, Huangong Rd. Yongkang Tainan, Taiwan  
Phone: 886-6-2331003 Fax: 886-6-2333213  
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