

SMAW Electrodes for Nickel Steel (low temperature use)

GL86C3 / GL88C3

AWS A5.5M E5516(8)-C3
A5.5 E8016(8)-C3
JIS Z 3211 E5516(8)-N2

Product Features:

- Low hydrogen/ iron powder low hydrogen type covered electrode for low alloy low temperature steel (Ni steel).
- Good for RT examination, good mechanical properties.
- All deposited weld metal contains approximately 1.0% Ni elements, good for serving temperature till -40°C.

Applications:

- Suitable for welding of low temperature steel (Ni steel), serving temperature till -40°C.

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

C	Si	Mn	Ni
0.06	0.60	0.84	0.86

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-40°C) J	Post Weld Heat Treatment °C×1hr
546	620	24.2	80	Not defined

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	80~110	100~140	150~200	190~230
Vertical / overhead position	75~105	90~130	120~150	140~170

Note:

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

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