

For 490MPa High Tensile Strength Steel

APPLICATIONS

Welding of 490MPa high tensile strength steel for ships, structures, bridges and pressure vessels.

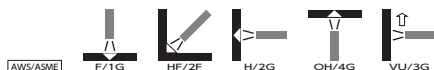
CHARACTERISTICS

L-55 is a low hydrogen type electrode for all positions. Weld metal shows excellent crack resistance, mechanical properties and X-ray quality. Vertical and overhead welding is very easy.

GUIDELINES FOR USAGE

1. Electrodes should be redried at 300~350°C for 60 minutes before use.
2. Backstep method should be applied to prevent blowholes and pits at arc starting and arc length should be kept as short as possible during welding.
3. All water, rust and oil in groove should be completely removed to prevent cracks and blowholes.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S
0.07	0.62	1.18	0.011	0.008

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at -30°C, J
480	550	30	160

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.6	3.2	4.0	5.0	6.0	8.0
Length (mm)		300	400	450	450	450	450
Current A	F, H-Fil, H	60~110	70~140	120~190	190~240	250~300	340~390
	V-up, OH	60~90	60~130	90~150	130~170	—	—

Identification color: End-light green, secondary-yellow