

# TL-50D

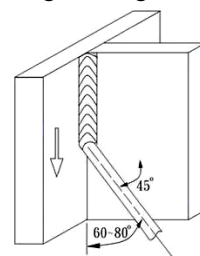
AWS A5.1 E7048  
EN ISO 2560-B-4948-A  
JIS Z 3211 E4948

## Characteristics and Applications:

TL-50D is designed for exclusive use in vertical downward welding. Slag release and crack resistibility are excellent. It is suitable for the vertical downward welding of steel, structures, and ship buildings, bridge.

## Notes on usage:

1. Dry the electrodes at 300-350 for 30-60 minutes, and then keep at 100-150 before using.
2. For vertical downward welding, manipulate the electrode as shown in figure, Do not use balance arc.
3. Do not exceed the range of proper currents. Over heat input decrease hurt the impact toughness.



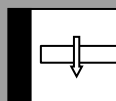
## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S
0.08	1.00	0.55	0.02	0.006

## Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20 )
445(65)	550(80)	28	78(58)

## Welding position:



## Sizes and recommended current range (AC or DC + ):

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	450	450
Amps	VD 110-160	140-210	210-240

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Other tests and procedures may produce different results.

The information contained or otherwise referenced herein is presented only as "typical" without  
incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS spe  
This data is not intended as recommendation for any use outside of the scope of the product.

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