

TL-50D

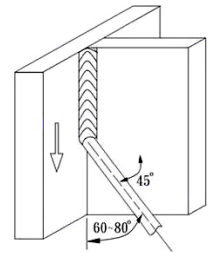
AWS A5.1 E7048
EN ISO 2560-B-4948-A
JIS Z 3211 E4948

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 °C for 30-60 minutes, and then keep at 100-150 °C 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.



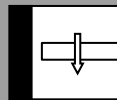
Typical chemical composition of weld metal (wt%):

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 °F)
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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The information contained or otherwise referenced herein is presented only as "typical" without any guarantee or warranty. Typical data is obtained when welded and tested in accordance with AWS specifications. This data is not intended as a recommendation for any welding application. For more information, please contact Tientai Electrode Co., Ltd.