

TL-508

AWS A5.1 E7018
EN ISO 2560-A-E 42 3 B 3 2 H10
JIS Z 3211 E4918

Characteristics and Applications:

TL-508 is a low hydrogen type electrode for the welding of 490N/mm² grade high tensile steel. The welding can be done with high deposition rate, good X-ray soundness and mechanical properties. It is especially suitable for nuclear power stations, petroleum chemical plants, and heavy steel plates. Proper base metals such as: structural steel, steel casting, thin plate, steel strip, carbon steel tube, etc..

Notes on usage:

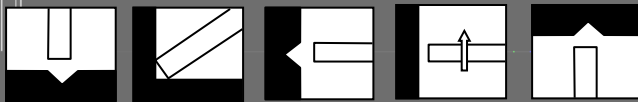
1. Bake the electrodes at 300-350 for 60 minutes before using. Take out a batch of half day consumption

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0.065	1.30	0.55	0.020	0.008

Typical mechanical properties of weld metal :

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf) -30°C (-20)
500(73)	580(84)	28	135(100)

Welding position:



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

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	350 450	450
Amps	F	80-110	90-130	140-180	170-240
	V&OH	70-100	80-120	120-160	150-180

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