

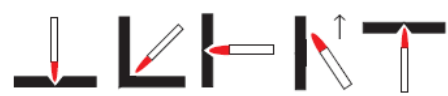
HEAT RESISTING STEEL
GLST-78A1 ELECTRODE

Classification: AWS A5.5 E7018-A1
EN E Mo B 42

Characteristics and Application:

GLST-78A1 is an iron powder and low hydrogen type stick electrode, in which the mormal weld metal chemical composition is 0.5%Mo. Because of Mo, the strength and heat resistance of weld metal will be higher but the notch toughness might be lower. It is suitable for welding C-Mo steel to be used at high temperatures up to 500°C, such as boiler, heat exchangers and petroleum refinery plants.

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Mo	P	S
AWS	0.152	0.90	0.60	-	0.40-0.65	0.03	0.03
Type Value	0.08	0.74	0.45	-	0.53	0.02	0.012

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C	PWHT
AWS	390	490	22	27/20	620°C±15°C/1hr
Type Value	465	540	24	110/20	620°C±15°C/1hr

Notes on Usage:

- 1 Dry the stick electrodes at 350-400°C for one hour before welding.
- 2 Preheating and interpass temperature at 90-110°C and try to keep interpass temperature.
- 3 Keep short arc length when welding.To avoid blowholes when striking the arc, please use backstep method welding technique during welding process.
- 4 To relieve stress, PWHT at 605-635°C.
- 5 Current type:DC or AC
- 6 Keep low hydrogen situation during whole welding proess.

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×400	5.0×450
Current/Amp	F	55-85	90-130	140-1890	190-240
	V, OH	50-80	80-120	120-160	-