

Classification: AWS A5.1 E7018-1

EN E 46 5 B 32 H5

ISO 2560 B-E4918-1A

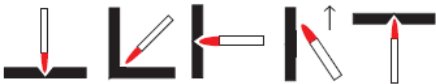
HIGH TENSILE STRENGTH STEEL

GLST-58 ELECTRODE

Characteristics and Application:

GLST-58 is an iron powder and low hydrogen type stick electrode, which is suitable for all position welding. It offers high deposition efficiency, excellent mechanical property and X-Ray. It is suitable for the welding of offshore platform, port machinery, shipbuilding and pressure vessels.

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.15	1.60	0.75	0.20	0.30	0.30	0.035	0.035	0.08
Type Value	0.080	1.32	0.51	0.03	0.04	0.03	0.020	0.015	0.02

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C
AWS	400	490	22	27/30
Type Value	475	570	289	120/-30

Notes on Usage:

- 1 Dry the stick electrodes at 350°C for one hour before welding.
- 2 Be sure to remove moisture, oil and rust on the base metal.
- 3 To avoid blowholes when striking the arc, please use backstep method welding technique during welding process.
- 4 Keep short arc length when welding; if the weave is permitted, the width is less than 3 times diameter.
- 5 Current type:DC or AC

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×450	5.0×450
Current/Amp	F	55-85	90-130	130-180	180-250
	V, OH	50-80	90-120	130-160	-