

Classification: AWS A5.5 E10018-G

A5.5M E7016-G

EN 62 4 Mn1.5NiMo B 4 2 H5

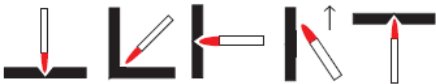
HIGH TENSILE STRENGTH STEEL

GLST-78 ELECTRODE

Characteristics and Application:

GLST-78 is for welding of 690Mpa high tensile strength steels for storage tanks, offshore structures, pressure vessels, and construction machinery. which is suitable for all position welding. It offers high resistance to crack, excellent mechanical property and X-Ray.

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V	Cu
AWS	0.12	≥1.00	≥0.80	-≥0.30	≥0.50	≥0.20	0.03	0.03	0.1	≥0.20
Type Value	0.08	1.65	0.45	0.03	0.95	0.45	0.010	0.007	0.001	0.03

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C
AWS	600	690	16	27/-40
Type Value	650	730	25	50/-40

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	-