

Classification: AWS A5.5 E11018-G

EN 69 5 Mn2NiMo B 3 2 H5

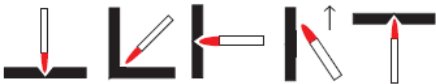
HIGH TENSILE STRENGTH STEEL

GLST-88 ELECTRODE

Characteristics and Application:

GLST-88 is for welding of 780Mpa high tensile strength steels for offshore structures, pressure vessels, and storage tank and construction machinery. It is a low hydrogen type electrode. The welding can be done in all position with AC/DC. It has excellent weld ability stable arc, nice molding, exquisite ripple, and little spatter, good slag detachability, high X-Ray eligibility rate.

Welding Position :



Chemical Composition of Deposited Metal :

ELEMENT wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.10	1.30-1.80	0.60	0.40	1.25-2.50	0.25-0.50	0.03	0.03	0.05
Type Value	0.08	1.40	0.48	0.32	1.62	0.40	0.010	0.008	0.01

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C
AWS	670	760	15	27/-50
Type Value	710	820	23	70/-50

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	4.0×400	5.0×400
Current/Amp	F	55-85	90-130	130-180	180-250
	V, OH	50-80	90-120	130-160	-