



MT-48 LOW HYDROGEN ELECTRODE FOR WELDING HIGH TENSILE STEEL



MT- 48

**Corresponding to AWS E7018
JIS D5016
GB E5018**

Low hydrogen electrode for welding high tensile steel

Description:

MT-48 is low hydrogen type electrodes containing iron powder for ordinary low alloy steel. As the covering contains iron powder, it welds with high efficiency, the melting rate is around 110%. It operates in all positions on DC and AC (AC open circuit voltage $\geq 70V$.) The deposited metal has high plasticity, better toughness and crack resistance.

Applications:

For welding key structures and 50Kg/mm² class high tensile steel of ships and bridges.

Typical Chemical Composition of Weld Metal (%)

C	Mn	Si	S	P
0.08	1.00	0.50	0.014	0.02

Typical Mechanical Properties of Weld Metal

Yield Strength	Tensile Strength	Elongation (%)	Charpy V Impact Value (-20 ⁰ C)	Bend Test (Degree)
480N/mm ²	570N/mm ²	30	127J	180

Note on usage:

Dry electrodes at 350⁰C for one hour before use.