SL® 22G

TOP FEATURES

- Maximum service temperature 550°C AC/DC electrode + or –. DC welding by preference. Root pass in open joints, electrode negative preferable 115 - 120% recovery Only available in vacuum sealed Sahara ReadyPack®(SRP)
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- 115 - 120% recovery

CLASSIFICATION

AWS A5.5	E 8018-B1-H4
EN ISO 3580-A	E Z B 32 H5

CURRENT TYPE

AC / DC (+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Mo	HDM
0.06	0.8	0.6	0.020	0.010	0.5	0.5	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-10°C
Required: AWS A5.5	SR(1)	min. 460	min. 550	min. 19	not specified	
Typical values	SR(2)	570	640	24	180	110

Stress relieved: SR(1) = 690±14°C/1h, SR(2) = 730°C/1h

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	60-90
3.2x350	80-130
4.0x350	120-180
5.0x450	160-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
2.5x350	SRP	63	1.3	524246-1
3.2x350	SRP	50	1.5	524284-1
4.0x350	SRP	28	1.9	524277-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.