

# TL 36

**International Standards:**

AWS SFA 5.1 : E 7016  
 JIS Z 3212 : D 5016  
 DIN 1913 : E 51 44 B10  
 DIN EN 499 : E 42 2 B12 H10

**Applications and Properties :**

TL 36 is a low hydrogen type electrode for welding high tensile steel. The welding can be done with stable arc, less spatters, good slag removability, good slag covering and good X-Ray soundness. It's suitable for low alloy steels, medium carbon steels, heavy steel plates, cast steels and steels of poor weldability.

**Aplikasi dan Penggunaan :**

TL 36 adalah kawat las low hydrogen untuk pengelasan baja berkekuatan tinggi. Pengelasan memiliki kestabilan nyala api yang sangat baik, spatter yang rendah, pelepasan terak yang mudah, dan performa X-ray yang baik. Sangat cocok untuk baja karbon rendah, baja karbon sedang, pelat baja, ancuran, dan baja yang sulit dilas.

**Typical Chemical Analysis of Deposited Metal (%) :**

C	Mn	Si	P	S
0,08	1,00	0,53	0,012	0,008

**Typical Mechanical Properties of Deposited Metal :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Value (Joule)	
			-20°C	-40°C
490	560	31	132	-

**Size & Recommended Current Range (DC or AC) :**

Size (mm)	2,6 x 350	3,2 x 350	4,0 x 400	5,0 x 400
Amperages (Amp)	55 - 85	90 - 130	130 - 180	180 - 240
Weight / pack (kgs)	5	5	5	5
Weight / carton (kgs)	20	20	20	20

**Welding Positions :**

**Attention!**  
 Redrying: 200°C/2h



**SYMBOL OF QUALITY**

**Manufactured by:**

**PT. Lion Superior Electrodes**

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