

TL 77

International Standards:

AWS SFA 5.1 : E 7018
 JIS Z 3212 : D 5016
 DIN 1913 : E 51 44 B10
 DIN EN 499 : E 42 3 B32 H10

Applications and Properties :

TL 77 is a low hydrogen type electrode for the welding of 490 N/mm² grade high tensile steel. The welding can be done with high deposition rate, good X-Ray soundness and mechanical properties. It is especially suitable for nuclear power stations, petroleum chemical plants, and heavy steel plates.

Aplikasi dan Penggunaan :

TL 77 adalah kawat las low hydrogen untuk pengelasan baja berkekuatan 490 N/mm². Pengelasan memiliki laju deposisi yang tinggi, performa x-ray yang baik, kekuatan mekanik yang baik. Sangat cocok untuk pengelasan pembangkit listrik tenaga nuklir, pabrik petrokimia, dan pelat baja.

Typical Chemical Analysis of Deposited Metal (%) :

C	Mn	Si	P	S
0,08	1,00	0,60	0,020	0,010

Typical Mechanical Properties of Deposited Metal :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact Value (Joule)	
			-20°C	-40°C
510	590	29	162	-

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	170 - 230
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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