

# TL-50D

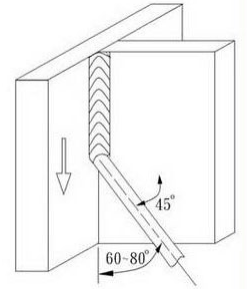
JIS Z 3212 D5016  
AWS A5.1 E7048  
EN499 E 42 3 B 1 5

## Characteristics and Applications:

TL-50D is designed for exclusive use in vertical downward welding. Slag release and crack resistibility are excellent due to its low hydrogen content. It is suitable for the vertical downward welding of steel, structures, and ship buildings, bridge.

## Notes on Usage:

1. Dry the electrodes at 300-350°C for 30-60 minutes, and then keep at 100-150°C before use.
2. For vertical downward welding, manipulate the electrode as shown figure, Do not use balance arc..
3. Do not exceed the range of proper currents. Over heat input might hurt the impact toughness.



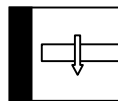
## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.08	1.00	0.50	0.015	0.008

## Typical mechanical properties of weld metal

YS (MPa)	TS(MPa)	EL %	CVN , J	
			0°C	-30°C
485	570	31	216	188

## Welding position



## Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	VD	110-160	140-210	210-240

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