

Stick Electrode for Atmospheric Corrosion Resistant Steel

KAC-03G

Classification

AWS	—	—
JIS	Z3214	E4903-NCC2
EN	—	—
GB	T 5118	E5003-G

Type of coating: Lime titania type

Applications and Features

- (1) It is suitable for welding 490N/mm² grade weather resistant steel.
- (2) Weld metal has great weather resistance and corrosion resistance to seawater and waste water due to Cu, Ni and Cr contents.
- (3) It is ideal for welding in 400N/mm² and 490N/mm² grade weather resistant steel that is thinner than 9mm.

Welding Position

All Positions

Welding Instruction

- (1) Dry the electrodes at 80~100°C for 60 minutes before welding.
- (2) Please select proper welding current to prevent crack, porosity and undercut.

Typical Chemical Composition of Weld Metal (wt %)

C	Si	Mn	P	S	Cu	Cr	Ni
0.070	0.30	0.52	0.014	0.010	0.38	0.23	0.30

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
550(56.1)	460(46.9)	28	0	118(12.0)
			-20	—

Size and Suggested Operating Range (AC or DC±)

Diameter (mm) x Length(mm)		3.2x350	4.0x400	5.0x400
Amp	H	110~150	160~200	180~230
	V-up/OH	90~130	130~170	140~180