

Stick Electrode for High Tensile Strength Steel

KL-516

Classification

AWS	A 5.1/A 5.1M	E7016/E4916
JIS	Z3211	E4916
EN	2560-A	E42 3 B 1 2
GB	T5117	E5016

Type of coating: Low hydrogen type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel, low alloy steel, medium-carbon steel, heavy steel plates and cast steels.
- (2) Stable arc, easy control of weld puddle, low spatters, good slag removal and bead appearance, good penetration and X-ray quality.
- (3) Applicable for base metal of structural steel, steel tubes for heat exchanger, plate for pressure vessel, low-alloy steel tube and mechanical structural carbon-steel plate.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.53	1.02	0.012	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
568	468	29	0 -29	211 152

Size and Suggested Operating Range (AC or DC+)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/HF	90~130	130~180	180~240	230~300
	V-up/OH	80~120	110~160	150~200	-