

Stick Electrode for High Tensile Strength Steel

KL-50U

Classification

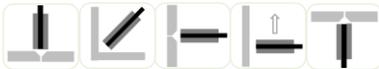
AWS	A 5.1/A 5.1M	E7016/E4916
JIS	Z3211	E4916
EN	2560-A	E42 3 B 1 1
GB	T5117	E5016

Type of coating: Low hydrogen type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) It particularly designed for the root pass welding.
- (3) Stable arc, good weldability and mechanical properties of weld metal, crack resistance.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.53	1.10	0.015	0.006

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
582	477	30	-29	133
			-41	61

Size and Suggested Operating Range (AC or DC+)

Diameter (mm)		2.6	3.2	4.0
Current (A)	Root pass of pipeline	30~80	60~110	90~140