

Stick Electrode for High Tensile Strength Steel

KL-53

Classification

AWS	A 5.1/A 5.1M	-
JIS	Z3211	E4903
EN	2560-A	E42 0 RB 1 2
GB	T5117	E5003

Type of coating: Lime titania type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) Stable arc, low spatters, easy control of weld puddle, good slag removal, appropriate penetration, good mechanical properties, easy to re-start and smooth welding bead.
- (3) Applicable for welding on ship building, bridge and steel structures

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.39	0.94	0.018	0.009

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
530	480	30	0	74

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/H-Fillet	90~150	130~190	180~240	230~300
	V-up/OH	80~120	110~160	150~200	-