

# KL-514

**Classification**

AWS	A 5.1/A 5.1M	E7014/E4914
JIS	Z3211	E4914
EN	2560-A	E42 0 R 1 2
GB	T5117	E5014

Type of coating: Rutile type

**Applications and Features**

- (1) Suitable for welding 490N/mm<sup>2</sup> grade steel.
- (2) Good arc starting and re-start, stable arc, low spatters, good slag removal and good bead appearance.
- (3) Applicable for welding on automobiles steel plate, sheet metal, light structure steel and underwater welding. Ideal for welding thin sheet due to the less penetration.

**Welding position****Welding Instruction**

Please refer to Appendix A.

**Typical Chemical Composition of Weld Metal (wt%)**

C	Si	Mn	P	S
0.08	0.31	0.52	0.019	0.007

**Typical Mechanical Properties of Weld Metal**

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
536	462	22	0	70

**Size and Suggested Operating Range (AC or DC±)**

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