

Stick Electrode for High Tensile Strength Steel

KL-526

Classification

AWS	A 5.1/A 5.1M	E7028/E4928
JIS	Z3211	E4928
EN	2560-A	E42 2 B 5 3
GB	T5117	E5028

Type of coating: Iron powder low hydrogen type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) Low spatters, high deposition rate (about 150%) and good crack resistance.
- (3) Applicable for shipbuilding, bridges and vehicles. Ideal for the flat /horizontal position and gravity welding.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.23	0.58	0.012	0.010

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
540	490	28	0	98
			-18	82

Size and Suggested Operating Range (AC or DC+)

Diameter (mm)	3.2	4.0	5.0	6.0	
Current (A)	F/H-Fillet	160~200	200~240	230~270	300~350