

FOR CARBON STEEL

AWS E6010
JIS D4311
KS E4311

KCL-10

Typical applications

Shipbuildings, pressure pipe, tanks with plain or galvanized surfaces and steel casting repairs.

Coating

High cellulose type.

Characteristics on Usage

- ① Good penetration combined with freedom from lack of fusion makes this electrode an excellent choice for pipeline welding.
- ② Gives high ductility root weld.
- ③ Easy slag removal.
- ④ Redry the electrode at 70~80°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.10	0.20	0.47	0.014	0.012

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J{kgf · m} (-29°C)
420 {43}	500 {51}	24	50 {5}

Sizes available and recommended currents (DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	50~80	70~110	110~150	160~200
	V&OH	40~70	60~100	90~130	140~170

Welding positions



Approved by

ABS, BV, CWB, LR, NK, JIS