

FOR CARBON STEEL

AWS E6027
JIS D4327
KS E4327

KF-300LF

Typical applications

Flat and horizontal fillet welding of ship hull constructions, bridges, structural steels for buildings and general structures.

Coating

High iron oxide, iron powder type.

Characteristics on Usage

- ① Beautiful bead appearance without undercut and easy slag removal.
- ② Extremely high efficient welding because of high deposition rate by much iron powder.
- ③ Redry the electrode at 120~150°C for 60 minutes prior to use.

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

C	Si	Mn	P	S
0.08	0.35	0.86	0.016	0.010

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)
410 {42}	470 {48}	32	60 {6}

Sizes available and recommended currents (AC or DC ⊕, ⊖)

Dia.	(mm)	4.0	4.5	5.0	5.5	6.0	6.4
Length	(mm)	550	550	550	550	550	550
			700	700	700	700	700
Amp.	F	150~180	180~200	180~230	220~270	250~290	280~310
	H-Fil						
각장	(mm)	5.0~5.5	5.5~6.0	6.0~6.5	6.5~7.0	7.0~8.0	7.5~8.5

Welding positions



Approved by

ABS, BV, DNV, GL, KR, LR, NK, JIS, KS