

KH-500LF

AWS E7016
JIS D4316
KS E4316

FOR CARBON STEEL

Typical applications

Welding of strength members of ship hulls and general heavy structural steels, free cutting steels, medium carbon steels, high sulphur steel.
 Underlaying of hardfacing.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent crack resistance even in the welding of difficult-to-weld steels.
- ② Excellent mechanical properties and radiographic soundness.
- ③ Easy slag removal.
- ④ Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	P	S
0.07	0.46	0.97	0.012	0.009

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 {kgf · m} (-29°C)
460 {47}	540 {55}	34	140 {14}

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	60~90	90~130	140~190	180~230	250~300
	V&OH	50~80	80~110	120~160	160~200	-

Welding positions



Approved by

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