

FOR CARBON STEEL

AWS E7048  
JIS D4316  
KS E4316

# KH-500VLF

## Typical applications

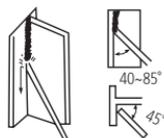
Vertical-down welding of general structures and strength members of ship construction, machinery, pressure vessels, buildings and bridges.

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① Fully satisfactory working efficiency in vertical- down welding.
- ② Excellent mechanical properties and crack resistance.
- 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
0.08	0.48	0.90	0.013	0.010

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
440 {45}	550 {56}	33	90 {9}

## Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	3.2	4.0	4.5	5.0	5.5
Length	(mm)	400	450	450	450	450
Amp.	V-down	120~160	150~210	180~240	220~280	260~330

## Welding positions



## Approved by

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