

# KH-500W

AWS E7016  
JIS D4316  
KS E4316

FOR CARBON STEEL

## Typical applications

One-side welding of pipes and general butt joint of ships, pressure vessels,

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① Specifically designed for one-side welding of pipes and general structures.
- ② Extremely good usability in flat positions.
- 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	0.58	0.90	0.013	0.010

## Typical mechanical properties of all-weld-metal

Y · P	T · S	EI	Charpy V-notch
N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	(%)	J {kgf · m} (-29°C)
460 {47}	560 {57}	32	80 {8}

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

Dia.	(mm)	2.6	3.2	4.0	4.5	5.0
Length	(mm)	350	350	400	400	400
Amp.	F	30~70	60~110	90~140	120~160	130~180
	OSW					

## Welding positions



## Approved by

ABS, DNV, JIS, KS