

FOR CARBON STEEL

AWS E6019
JIS D4301
KS E4301

KI-101LF

Typical applications

Welding of high pressure boilers, machinery for generating electric power plant, ship hulls, rolling stocks, buildings, bridges and other structural fabrications.

Coating

Ilmenite type.

Characteristics on Usage

- ① Free from pits and good radiographic soundness.
- ② The most excellent mechanical properties and also suitable for welding of structural steels of heavy section about 25mm thickness.
- ③ Redry the electrode at 70~100°C for 60 minutes prior to use.

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

C	Si	Mn	P	S
0.09	0.12	0.48	0.014	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 }	El (%)	Charpy V-notch J{kgf · m} (0°C)
400 {41}	460 {47}	34	120 {12}

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	80~135	135~190	180~240	250~310
	V&OH	50~75	60~120	100~160	135~210	-

Welding positions



Approved by

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