

KK-50LF

AWS E7016
JIS D5016
KS D5016

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

Welding of 490N/mm² class high tensile strength steel in ships, bridges, buildings and pressure vessels.

Coating

Low hydrogen type.

Characteristics on Usage

- ① The most popular electrode for 490N/mm² class high tensile strength steel.
- ② Excellent usability in all positions and high quality of deposited weld metal.
- ③ Redry the electrode at 350~400°C for 60 minutes prior to use.

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

C	Si	Mn	P	S
0.08	0.57	1.02	0.015	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)
480 {49}	560 {57}	32	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	180~240	250~310
	V&OH	50~80	80~120	110~170	160~200	-

Welding positions



Approved by

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