

KK-50N

AWS E7016-G
JIS DL5016-4A0
KS DL5016-4A0

FOR LOW TEMPE-
RATURE SERVICE STEEL

Typical applications

Welding of aluminium-killed steel to be used for LPG tankers, LPG storage tanks, machineries and structures.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent notch toughness of deposited weld metal at low temperature.
- ② Redry the electrode at 300~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	Ni
0.08	0.42	1.35	0.47

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} (-45°C)
490 {50}	570 {58}	30	130 {13}

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	50~100	70~130	150~190	220~250	250~310
	V&OH	30~80	70~100	120~160	150~200	-

Welding positions



Approved by

DNV, LR