

FOR LOW TEMPE-
RATURE SERVICE STEEL

AWS E7016-G
JIS DL5016-6A1
KS DL5016-6A1

KK-50NN

Typical applications

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

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 60 minutes prior to use.

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

C	Si	Mn	Ni
0.07	0.37	1.45	1.37

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}	
			(-60°C)	(-50°C)
520 {53}	590 {60}	30	130 {13}	160 {16}

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	250~300
	V&OH	30~80	70~100	120~160	130~200	-

Welding positions



Approved by