

FOR HIGH TENSILE
STRENGTH STEEL

AWS E8016-G
JIS D5316
KS D5316

KK-55

Typical applications

Welding of 540N/mm² class high tensile strength steel of pressure vessels, bridges, penstocks and rails

Coating

Low hydrogen type.

Characteristics on Usage

- ① Good strength property of deposited weld metal.
- ② Excellent weldability and usability.
- ③ Satisfactory bead appearance and good slag removal.
- ④ Excellent radiographic soundness.
- ⑤ Redry the electrode at 350~400°C for 30~60minutes prior to use.

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

C	Si	Mn	P	S
0.08	0.50	1.20	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 }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
540 {55}	600 {61}	28	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	60~90	90~130	140~190	180~240	250~300
	V&OH	50~80	80~120	110~170	160~200	-

Welding positions



Approved by