

KK-60

AWS E9016-G
JIS D5816
KS D5816

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

Welding of 590N/mm² class high strength low alloy steel of pressure vessels, penstocks, bridges, vehicles and machinery

Coating

Low hydrogen type.

Characteristics on Usage

- ① Mn-Ni-Mo type deposited weld metal.
- ② Minimum hydrogen content and very satisfactory crack resistance.
- ③ Satisfactory radiographic soundness.
- ④ Good impact value.
- ⑤ Redry the electrode at 350~400°C for 60 minutes prior to use.

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

C	Si	Mn	Ni	Mo
0.07	0.58	1.04	0.64	0.26

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)	PWHT
550 {56}	650 {66}	29	140 {14}	As welded
550 {56}	660 {67}	31	150 {15}	620°C X 1hr. S · R

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 V&OH	60~90 50~80	90~130 80~110	140~190 120~170	180~230 160~200	250~300 -

Welding positions



Approved by