FOR HIGH TENSILE STRENGTH STEEL

AWS E10016-G
JIS D7016
KS D7016

KK-70

Typical applications

Welding of 690N/mm² class high strength low alloy steel, yield point is 620N/mm² of pressure vessels, penstocks and bridges

Coating

Low hydrogen type

Characteristics on Usage

① Excellent usability and radiographic soundness in all positions.
② Good crack resistance.
③ Redry the electrode at 350~400℃ for 60 minutes prior to use, and store the electrode at 100~150℃ after redrying, keep them away from moisture.

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

C	Si	Mn	Ni	Mo
0.08	0.37	1.05	1.87	0.40

Typical mechanical properties of all-weld-metal

Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	Charpy V-notch J {kgf · m} (-29℃)
640 {65}	730 {74}	26	120 {12}

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	180~230	250~300
	V&OH	50~80	80~110	120~170	160~200	–

Welding positions

Approved by