

KK-80 AWS E11016-G
 JIS D8016
 KS D8016

FOR HIGH TENSILE
 STRENGTH STEEL

Typical applications

Welding of 790N/mm² class high strength low alloy steel, minimum yield point 690N/mm² of pressure vessels, penstocks and bridges.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Good crack resistance.
- ② Satisfactory radiographic soundness and notch toughness.
- ③ Redry the electrode at 350~400°C for 60 minutes prior to use, and store the electrode at 100~150°C after redrying.

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

C	Si	Mn	Cr	Ni	Mo
0.07	0.60	1.10	0.15	1.84	0.43

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)
730 {74}	830 {85}	22	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