

KW-50G

AWS E7016-G
JIS DA5016W
KS DA5016W

FOR ATMOSPHERIC
CORROSION RESISTING STEEL

Typical applications

Welding of 490N/mm² class high tensile strength weathering type structural steels for vehicles, building and bridges.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent weather-proof property and crack resistance.
- ② Redry the electrode at 350~400°C for 60 minutes prior to use.

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

C	Si	Mn	Cr	Ni	Cu
0.06	0.46	0.74	0.52	0.63	0.40

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	El (%)	Charpy V-notch J {kgf · m} (0°C)
530 {54}	620 {63}	28	160 {16}

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	3.2	4.0	5.0	6.0	
Length (mm)	350	400	400	450	
Amp.	F V&OH	90~130 70~110	150~190 120~160	180~230 130~170	240~280 -

Welding positions



Approved by