

FOR ATMOSPHERIC
CORROSION RESISTING STEEL

AWS E7016-G
JIS DA5016G
KS DA5016G

KW-50V

Typical applications

Vertical-down 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 working efficiency in vertical-down welding.
- ② Excellent weather-proof property and crack resistance.
- ③ Redry the electrode at 350~400°C for 60 minutes prior to use.

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

C	Si	Mn	Ni	Cu
0.06	0.54	0.86	0.60	0.27

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} (0°C)
440 {45}	540 {55}	32	170 {17}

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp.	V-down	120~160	170~210	220~280

Welding positions



Approved by