

FOR ATMOSPHERIC
CORROSION RESISTING STEEL

JIS DA5026W
KS DA5026W

KW-50WH

Typical applications

Flat and horizontal fillet welding of 490N/mm² class high tensile strength weathering type structural steel for buildings, bridges and other steel structures

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① Extremely high deposition rate and easy slag removal.
- ② Redry the electrode at 350~400°C for 30~60 minutes prior to use.

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

C	Si	Mn	Cr	Ni	Cu
0.07	0.30	0.92	0.54	0.53	0.39

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)
510 {52}	560 {57}	26	70 {7}

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	4.0	5.0	5.5	6.0
Length	(mm)	450	450~550	450~550	450~550
Amp.	F	160~200	200~250	220~270	250~300
	H-Fil				

Welding positions



Approved by