

Covered Electrodes

KI-101LF

For 420MPa mild steel

Classifications

EN ISO 2560-A:2006	: E 38 2 RA 12	KS D 7004	: E4301
EN ISO 2560-B:2006	: E 43 19 A U	JIS Z 3211	: E4319
AWS A5.1-04	: E6019		

Description

- Covering is ilmenite type for welding of high pressure boilers, ship hulls, building, bridges and other structural fabrications.
- The most excellent mechanical properties and also suitable for welding of structural steels of heavy section about 25mm thickness.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.15	0.47	0.020	0.012	0.01	0.02	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.1	min. 330	min. 430	min. 22		≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20		≥ 47	
Example	400	490	30	100	80	AW

* AW : As-Welded

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	80~135	135~190	180~240	250~310
(A)	V · OH	50~75	60~120	100~160	135~210	-

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3	3	3	3	3	3m	KMW3

* Others : KS, JIS, CE