

Covered Electrodes

KH-500W

For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 38 3 B 12 H10	KS D 7004	: E4316
EN ISO 2560-B:2006	: E 43 16 A H10	JIS Z 3211	: E4316
AWS A5.1-04	: E7016		

Description

- Specifically designed for one side welding of pipes and general structures.
- Covering is low hydrogen type for welding of all positions except vertical-down.
- Extremely good usability in flat positions.
- Easy slag removal and beautiful bead appearance.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.09	0.58	0.98	0.014	0.011	0.02	0.03	0.01	0.01	1.05

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
JIS Z 3211	min. 330	min. 430	min. 20		≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 47		
Example	460	560	32	70	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	4.5	5.0
Length	(mm)	350	350	400	400	400
Amp.(A)	F _{IT} OSW	30~70	60~110	90~140	120~160	130~180

Approvals

KS, JIS, CE