

KH-500VLF

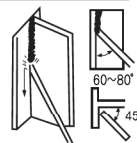
For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 38 0 B 35 H10	KS D 7004	: E4316
EN ISO 2560-B:2006	: E 43 16 A H10	JIS Z 3211	: E4948
AWS A5.1-04	: E7048		

Description

- Covering is low hydrogen type for vertical-down welding of general structures and strength members of machinery, ship construction, bridges.
- In vertical-down welding, excellent bead appearance can be obtained by taking a little bit higher welding amperage and holding the electrode at the illustrated angles.
- Excellent mechanical properties and crack resistance.
- 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
0.06	0.53	0.72	0.012	0.011	0.02	0.03	0.01	0.01	0.79

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 47		
Example	440	550	33	70	60	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	4.5	5.0	5.5
Length	(mm)	400	450	450	450	450
Amp.(A)	V-down	120~160	150~210	180~240	220~280	260~330

Approvals

ABS	BV	DNV	KR	LR	NK
3YH10	3YHH	3YH10	3YH15	3YmH15	KMW3H

* Others : KS, JIS, CE