

Covered Electrodes

KK-50LF

For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 42 3 B 12 H10	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 16 A U H10	JIS Z 3211	: E4916
AWS A5.1-04	: E7016		

Description

- Covering is low hydrogen type for welding of 490MPa class high tensile steel in ships, bridges.
- Excellent mechanical properties and radiographic soundness.
- Excellent crack resistance even in the welding of difficult to weld steels.
- Satisfactory bead appearance and slag removal.
- 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
0.07	0.53	0.93	0.013	0.012	0.02	0.03	0.01	0.01	1.00

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	480	560	32	110	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	90~130	140~190	180~240	250~310
(A)	V · OH	50~80	80~110	120~160	160~200	—

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH10	3YHH	3YH10	3YH10	3YH15	3YmH15	KMW53H

* Others : KS, JIS, CE