

Covered Electrodes

KK-70

For 690MPa high tensile steel

Classifications

EN 757:1997 : E 55 3 Z B 12 H10
AWS A5.5-06 : E10016-G

KS D 7006 : E7016
JIS Z 3211 : E6916-G

Description

- Covering is low hydrogen type for welding of 690MPa class high strength low alloy steel, yield point 620MPa of pressure vessels, penstocks and bridges.
- Satisfactory bead appearance and slag removal.
- Excellent crack resistance and radiographic soundness.
- 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
0.07	0.49	1.05	0.015	0.011	1.87	0.05	0.37	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.5	min. 600	min. 690	min. 16			
EN ISO 2560-A	min. 550	610~780	min. 18		≥ 47	
Example	640	730	26	100	90	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	180~230	250~300
(A)	V · OH	50~80	80~110	120~170	160~200	—

Approvals

JIS, CE