

**Classifications**

KS D 7101 : DA5026W  
 JIS Z 3214 : DA5026W

**Description**

- Covering is low hydrogen, iron powder type for flat and horizontal fillet welding of 490MPa class high tensile strength weathering type structural steel for buildings, bridges and other steel structures.
- Extremely high deposition rate and easy slag removal.
- Quiet and stable arc.
- 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	Cu
0.07	0.30	0.92	0.015	0.012	0.53	0.51	0.01	0.39

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
JIS Z 3214	min. 390	min. 490	min. 23	≥ 47		
Example	510	560	27	65	40	AW

\* AW : As-Welded

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	4.0	5.0	5.5	6.0
		400	450	450	450
Length	(mm)		500	500	500
			550	550	550
Amp. (A)	F H-fillet	160~200	200~250	220~270	250~300