

## Covered Electrodes

# KW-60G

For atmospheric corrosion resisting steel

### Classifications

|                    |                 |            |           |
|--------------------|-----------------|------------|-----------|
| EN ISO 2560-A:2006 | : E 50 0 Z B 12 | KS D 7101  | : DA5816W |
| EN ISO 2560-B:2006 | : E 55 16-G A   | JIS Z 3214 | : DA5816W |
| AWS A5.5-06        | : E8016-G       |            |           |

### Description

- Covering is low hydrogen type for welding of 560MPa class high tensile strength weathering type structural steel for buildings, bridges and other steel structures.
- Excellent weather-proof property and crack resistance.
- 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   | Cu   |
|------|------|------|-------|-------|------|------|------|------|
| 0.07 | 0.65 | 0.75 | 0.016 | 0.011 | 0.62 | 0.53 | 0.01 | 0.50 |

### Typical mechanical properties of all-weld metal

|               | Y.S<br>(MPa) | T.S<br>(MPa) | El.<br>(%) | IV (J) |       | Remarks |
|---------------|--------------|--------------|------------|--------|-------|---------|
|               |              |              |            | 0°C    | -20°C |         |
| AWS A5.5      | min. 460     | min. 550     | min. 19    | ≥ 47   |       |         |
| EN ISO 2560-A | min. 500     | 560~720      | min. 18    |        |       |         |
| Example       | 530          | 590          | 24         | 100    | 70    | AW      |

\* AW : As-Welded

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

| Dia.        | (mm)        | 3.2              | 4.0                | 5.0                | 6.0          |
|-------------|-------------|------------------|--------------------|--------------------|--------------|
| Length      | (mm)        | 350              | 400                | 400                | 450          |
| Amp.<br>(A) | F<br>V · OH | 90~130<br>70~110 | 150~190<br>120~160 | 180~230<br>130~170 | 240~280<br>- |

### Approvals

CE