

## Covered Electrodes

# KA-50G

For 490MPa corrosion resisting steel against sulfic acid

### Classifications

EN ISO 2560-A:2006	: E 42 0 Z B 12 H10	JIS Z 3214	: E4916-G
EN ISO 2560-B:2006	: E 49 16-G A H10		
AWS A5.5-06	: E7016-G		

### Description

- It is designed for the mild and medium tensile steels that are used to flue gas desulfurization facilities.
- The weld metal contains Cu, Co alloy and has good anticorrosion against sulfic acid.
- 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	Cu	Co
0.05	0.41	0.62	0.015	0.011	0.30	0.13

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	T.S 500°C (MPa)	IV (J) 0°C	Remarks
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 27	
Example	520	605	30	430	50	AW

\* AW : As-Welded

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

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	400	400	450
Amp. (A)	F V · OH	70~110 60~90	90~130 70~110	150~190 120~160	180~230 130~170