

Covered Electrodes

KK-50NN

For low temperature service steel (490MPa)

Classifications

EN ISO 2560-A:2006	: E 42 5 Z B 12 H10	KS D 7101	: DL5016-6A1
EN ISO 2560-B:2006	: E 49 16-G A H10	JIS Z 3211	: E4916-G
AWS A5.5-06	: E7016-G		

Description

- Covering is low hydrogen type for welding of aluminium-killed steel to be used for LPG tankers, and LPG storage tanks, etc.
- Excellent notch toughness of deposited weld metal at low temperature.
- 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
0.07	0.37	1.45	0.013	0.010	1.37	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-50°C	-60°C	
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 2560-A	min. 420	500~640	min. 20	≥47		
Example	520	590	28	120	100	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. (A)	F V · OH	50~100 30~80	70~130 70~100	150~190 120~160	220~250 130~200	250~300 -

Approvals

CE