

Covered Electrodes

KF-300LF

For 420MPa mild steel

Classifications

EN ISO 2560-A:2006	: E 38 0 A 53	KS D 7004	: E4327
EN ISO 2560-B:2006	: E 43 27 A	JIS Z 3211	: E4327
AWS A5.1-04	: E6027		

Description

- Covering is high iron oxide, iron powder type for welding of flat and horizontal fillet welding of ship hull constructions, bridges and general structures.
- Beautiful bead appearance with undercut.
- Extremely high efficient welding because of high deposition rate by much iron powder.
- Easy slag removal.
- Redry the electrode at 120~150°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.47	0.76	0.020	0.014	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.1	min. 330	min. 430	min. 22		≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 47		
Example	490	560	28	60	40	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC -)

Dia.	(mm)	4.0	4.5	5.0	5.5	6.0	6.4
Length	(mm)	550	550	550	550	550	550
			700	700	700	700	700
Amp. (A)	F H-Fillet	150~180	180~200	180~230	220~270	250~290	280~310
Leg	(mm)	5.0~5.5	5.5~6.0	6.0~6.5	6.5~7.0	7.0~8.0	7.5~8.5

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3	3	3	3	3	3m	KMW3

* Others : KS, JIS, CE