

Covered Electrodes

KW-50V

For atmospheric corrosion resisting steel

Classifications

AWS A5.5-06	: E7016-G
KS D 7101	: DA5016G
JIS Z 3214	: DA5016G

Description

- Covering is low hydrogen type for vertical-down welding of 490MPa class high tensile strength weathering type structural steel for vehicles, building and bridges.
- Excellent working efficiency in vertical-down welding.
- Excellent weather-proof property and crack resistance.
- 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	Cu
0.06	0.54	0.86	0.015	0.011	0.60	0.51	0.01	0.01	0.27

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.5	min. 390	min. 490	min. 22			
JIS Z 3214	min. 390	min. 490	min. 23	≥ 47		
Example	440	540	32	100	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0
Length	(mm)	350	400	400
Amp. (A)	V-down	120~160	170~210	220~280