

## Stick Electrode for High Tensile Strength Steel

# KL-50V

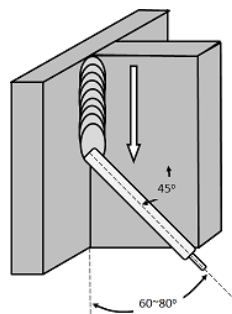
### Classification

AWS	A 5.1/A 5.1M	E7048/E4948
JIS	Z3211	E4948
EN	2560-A	E42 3 B 1 1
GB	T5117	E5048

Type of coating: Iron powder low hydrogen type

### Applications and Features

- (1) Suitable for vertical downward welding of 490N/mm<sup>2</sup> grade steel.
- (2) Easy control of weld puddle, low spatters, good slag removal and smooth bead, good penetration and X-ray soundness.
- (3) Good mechanical properties of weld metal, crack resistance and high deposition rate.
- (4) Applicable for ship building, bridge and steel structures.



### Welding position



### Welding Instruction

Please refer to Appendix A.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.50	1.01	0.012	0.008

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
560	485	31	0	208
			-29	142

### Size and Suggested Operating Range (AC or DC+)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	V-down	110~160	140~210	220~270	300~350