Stick Electrode for High Tensile Strength Steel

KL-514

Classification

AWS A 5.1/A 5.1M E7014/E4914 JIS Z3211 E4914

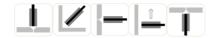
EN 2560-A E42 0 R 1 2
GB T5117 E5014

Type of coating: Rutile type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) Good arc starting and re-start, stable arc, low spatters, good slag removal and good bead appearance.
- (3) Applicable for welding on automobiles steel plate, sheet metal, light structure steel and underwater welding. Ideal for welding thin sheet due to the less penetration.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

С	Si	Mn	P	s	
0.08	0.31	0.52	0.019	0.007	

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm²	N/mm²	%	℃	J
536	462	22	0	70

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		3.2	4.0	5.0	6.0
Current	F/H-Fillet	90~130	130~180	180~240	230~300
(A)	V-up/OH	90~110	130~160	-	-