

KL-524

Classification

AWS	A 5.1/A 5.1M	E7024/E4924
JIS	Z3211	E4924
EN	2560-A	E42 0 RR 5 3
GB	T5117	E5024

Type of coating: Iron powder titania type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel with high deposition rate (about 160%).
- (2) Good weldability, low spatters, good slag removal and smooth bead appearance.
- (3) Applicable for fillet welds of T-beam or H-beam. Only one pass is needed to reach the required leg size without undercut.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.43	0.73	0.015	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	℃	J
540	485	25	0	72

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/H-Fillet	90~130	130~180	180~240	230~300
	V-up/OH	80~120	110~160	150~200	-