

## Stick Electrode for High Tensile Strength Steel

# KL-128

### Classification

AWS	A 5.5/A 5.5M	E12018-G/E8318-G
JIS	Z3211	E8318-N4C2M2
EN	18275-A	E69 2 Z B 3 2
GB	T5117	E8518-G

Type of coating: Iron powder low hydrogen type

### Applications and Features

- (1) Suitable for welding 830N/mm<sup>2</sup> grade steel.
- (2) Good weldability, low diffusible hydrogen content, good crack resistance, good mechanical properties.

### Welding position



### Welding Instruction

Please refer to Appendix A.

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.45	1.23	0.011	0.011	0.28	2.49	0.42

### 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
890	790	22	0	93
			-20	69

### 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	80~120	110~160	150~200	-