

# KT-42

## Classification

AWS A5.1/A5.1M	-
JIS Z3211	E4303
EN ISO 2560-A	E35 2 RB 1 2
GB T5117	E4303

Coating Type: Ilmenite

## Applications and Features

- ( 1 ) KT-42 is an electrode for mild steel suitable for light structures and steel plates with thickness on or below 25mm.
- ( 2 ) Excellent mechanical properties and X-ray quality welds, good crack resistance.
- ( 3 ) Stable arc, good re-strike, low spatter, and smooth bead appearance.
- ( 4 ) Good slag fluidity, easy slag removal after welding, and suitable for all-position welding.

## Welding Position



## Welding Instruction

Please see Appendix A

## Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S
0.08	0.08	0.45	0.014	0.008

## Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
470	400	28	0	95
			-20	75

## Available Sizes and Welding Parameters (AC/DC±)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/HF	80~120	120~170	170~240	230~300
	V-up/OH	60~110	110~160	-	-