

KT-401

Classification

AWS A 5.1/A5.1M	E6019/E4319
JIS Z3211	E4319
EN ISO 2560-A	E35 2 RA 1 2
GB T5117	E4319

Coating Type: Ilmenite

Applications and Features

- (1) KT-401 is an ilmenite type electrode for mild steel.
- (2) Excellent X-ray quality welds, good crack resistance, and superior mechanical properties.
- (3) Stable arc, low spatter, good flowability, easy slag removal, deep penetration, and good bead appearance.
- (4) Ideal for welding shipbuilding, machinery, building, automotive and bridge which is on or below 25mm.

Welding Position



Welding Instruction

Please see Appendix A

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S
0.09	0.10	0.47	0.022	0.007

Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
495	438	28	0	110
			-20	82

Available Sizes and Welding Parameters (AC/DC±)

Diameter (mm)		2.6	3.2	4.0	5.0	6.0
Current (A)	F/HF	70~110	110~150	130~190	170~240	230~300
	V-up/OH	40~70	60~120	110~160	-	-