

Stick Electrode for Mild Steel

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 ²	N/mm ²	%	°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	-	-