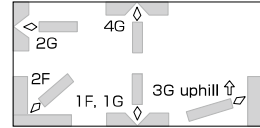


Stick electrode

- Features:**
- Suitable for butt and fillet welding of thin and thick plate (up to 20mm)
 - Good mechanical properties

Welding Positions:

Classification: AWS A5.1 E6019

Redrying Conditions: 70~100°Cx0.5~1h

Identification color: 1st Yellow

Polarity: AC, DCEP, DCEN

Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	19	170W, 100H, 380L
3.2	350	5	20	31	170W, 105H, 380L
4.0	400	5	20	57	170W, 95H, 430L
5.0	400	5	20	85	170W, 100H, 430L
6.0	450	5	20	154	170W, 95H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.09	0.20
Si	0.08	1.00
Mn	0.60	1.20
P	0.012	0.035
S	0.006	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	<0.01	0.08

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	40~70
3.2	80~130	60~110
4.0	120~180	100~150
5.0	170~250	130~200
6.0	240~310	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	420	331min.
TS (MPa)	470	414min.
EI on 4d (%)	31	22min.
IV -18°C (J)	80	27min.

Approvals

ABS	3
LR	3m
DNV-GL	3
BV	3
NK	KMW3
CR	3