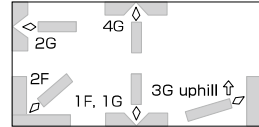


**Stick electrode**

- Features:**
- Suitable for butt and fillet welding of thin and thick plates (up to 20mm)
  - Better usability

**Welding Positions:**

**Classification:** AWS A5.1 E6019

**Redrying Conditions:** 70~100°Cx0.5~1h

**Identification color:** 1st Green

**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	30	170W, 105H, 380L
4.0	400	5	20	56	170W, 95H, 430L
5.0	400	5	20	84	170W, 95H, 430L
6.0	450	5	20	136	170W, 90H, 480L

**Composition (all-weld metal mass%)**

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.20
<b>Si</b>	0.09	1.00
<b>Mn</b>	0.39	1.20
<b>P</b>	0.016	0.035
<b>S</b>	0.008	0.035
<b>Ni</b>	0.01	0.30
<b>Cr</b>	0.02	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	<0.01	0.08

**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	230~300	-

Note: <sup>a</sup> Single values are maximum.

**All-weld mechanical properties**

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	400	331min.
<b>TS (MPa)</b>	450	414min.
<b>EI on 4d (%)</b>	30	22min.
<b>IV -18°C (J)</b>	68	27min.