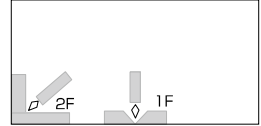


## Stick electrode

- Features:**
- Suitable for flat and horizontal fillet welding
  - Lime titania type

## Welding Positions:



**Classification:** AWS -

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

**Identification color:** 1st Purple, 2nd Orange

**Polarity:** AC, DCEP, DCEN

## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
4.0	450	5	20	76	170W, 90H, 480L
4.5	550, 700	5	20	138, 175	170W, 60~75H, 580~730L
5.0	450, 550, 700	5, 10	20	130, 159, 203	170W, 60~95H, 480~730L
5.5	450, 550, 700	5, 10	20	153, 187, 239	170W, 65~95H, 480~730L
6.0	450, 550, 700	5, 10	20	176, 215, 273	170W, 65~95H, 480~730L
6.4	450, 550, 700	5, 10	20	189, 231, 294	170W, 60~95H, 480~730L
7.0	700	10	20	350	170W, 60H, 730L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.13
<b>Si</b>	0.39	0.10~0.70
<b>Mn</b>	0.94	0.60~1.25
<b>P</b>	0.017	0.030
<b>S</b>	0.009	0.025
<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

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

## Welding parameters (A)

φ mm	1F, 2F
4.0	135~195
4.5	170~220
5.0	200~240
5.5	230~280
6.0	260~310
6.4	280~330
7.0	300~350

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	480	390min.
<b>TS (MPa)</b>	530	490min.
<b>EI on 4d (%)</b>	29	16min.
<b>IV 0°C (J)</b>	74	47min.

## Approvals

<b>ABS</b>	3, 3Y
<b>LR</b>	3Ym, 3YG
<b>DNV-GL</b>	3Y, MG
<b>BV</b>	3Y
<b>NK</b>	KMW53
<b>CR</b>	3Y