

Classifications

EN ISO 2560-A:2006	: E 42 0 B 52	KS D 7006	: E5026
EN ISO 2560-B:2006	: E 49 28 A	JIS Z 3211	: E4928
AWS A5.1-04	: E7028		

Description

- Covering is low hydrogen type for flat and horizontal fillet welding of 490MPa class high tensile steel.
- Extremely high deposition rate and good slag removal.
- For application of gravity welding and auto-contact welding.
- Quiet and stable arc.
- Redry the electrode at 200~250°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.06	0.37	0.98	0.021	0.013	0.02	0.03	0.01	0.01	1.05

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	470	550	31	65	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	5.0	5.5	6.0	6.4
		550	550	550	550
Length	(mm)	700	700	700	700
			900	900	900
Amp. (A)	F H-Fillet	200~250	220~280	270~320	290~340

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH10	3YHH	3YH10	3YH10	3YH10	3YmH15	KMW53H

* Others : JIS, CE