

KW-60G

AWS E8016-G
JIS DA5816W
KS DA5816W

FOR ATMOSPHERIC
 CORROSION RESISTING STEEL

Typical applications

Welding of 590N/mm² class high tensile strength weathering type structural steel for vehicles, building, bridges and other steel structures

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent weather-proof property and crack resistance.
- ② Redry the electrode at 350~400°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni	Cu
0.07	0.65	0.90	0.55	0.30	0.36

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-5°C)
530 {54}	590 {60}	24	90 {9}

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	3.2	4.0	5.0	6.0	
Length (mm)	350	400	400	450	
Amp.	F	90~130	150~190	180~230	240~280
	V&OH	70~110	120~160	130~190	—

Welding positions



Approved by