

KCL-10

For 420MPa mild steel

Classifications

EN ISO 2560-A:2006	: E 38 0 C 22
EN ISO 2560-B:2006	: E 43 10 A
AWS A5.1-04	: E6010
KS D 7004	: E4311
JIS Z 321	: E4310

Approvals

ABS	: 3,E6010
BV	: 3
DNV	: 3
LR	: 3m
NK	: KMW3
Other	: JIS, CE

Description

- Covering is high cellulose type for welding of pipe, shipbuilding, tanks or galvanized surfaces and steel casting repairs
- Good penetration combined with freedom from lack of fusion makes this electrode an excellent choice for pipe welding
- Gives high ductility root weld and easy slag removal
- Redry the electrode at 70 - 80 °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
0.11	0.36	0.63	0.015	0.013	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J)		Remarks
				0 °C	-30 °C	
AWS A5.1	Min. 330	Min. 430	Min. 22		≥ 27	
EN ISO 2560-A	Min. 380	470-600	Min. 20	≥ 47		
Example	420	500	29	60	40	AW

*AW: As-welded

Sizes available and recommended currents (DC+)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	350	350
Amperage	F	50-80	70-110	110-150	160-200
	V . OH	40-70	60-100	90-130	140-170