

KR-3000

For 420MPa mild steel

Classifications

EN ISO 2560-A:2006	: E 38 0 R 11
EN ISO 2560-B:2006	: E 43 13 A
AWS A5.1-04	: E6013
KS D 7004	: E4313
JIS Z 3211	: E4313

Approvals

ABS	: 2
BV	: 2
DNV	: 2
LR	: 2m
KR	: 2
NK	: NKY-1239
Other	: KS, JIS, CE

Description

- Covering is high titania type for welding of all kinds of light constructional work in all positions
- Excellent striking and restriking properties
- Excellent slag removal and bead appearance without undercut
- Redry the electrode at 70 - 100 °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
0.06	0.35	0.40	0.020	0.011	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
				RT	0 °C	
AWS A5.1	Min. 330	Min. 430	Min. 17			
EN ISO 2560-A	Min. 380	470-600	Min. 20		≥ 47	
Example	430	490	28	75	60	AW

*AW: As-welded

Sizes available and recommended currents (AC or DC +/-)

Diameter	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amperage	F	60-100	80-130	130-180	160-220	210-280
	V . OH	60-90	80-110	90-140	120-190	-