

# KT-401

**Classification**

AWS	A 5.1/A5.1M	E6019/E4319
JIS	Z3211	E4319
EN	2560-A	E35 2 RA 1 2
GB	T5117	E4319

Type of coating : Ilmenite type

**Applications and Features**

- ( 1 ) Suitable for butt or fillet welding of mild steel (thickness <20 mm), such as ship buildings, machines, steel structures, vehicles and bridges.
- ( 2 ) Excellent mechanical properties, capable of X-ray quality welds and crack resistance.
- ( 3 ) Stable arc, easy control of weld puddle, low spatters, good slag removal, bead appearance and good penetration.

**Welding position****Welding Instruction**

Please refer to Appendix A

**Typical Chemical Composition of Weld Metal (wt%)**

C	Si	Mn	P	S
0.09	0.10	0.47	0.022	0.007

**Typical Mechanical Properties of Weld Metal**

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	℃	J
495	438	28	0	110
			-20	82

**Size and Suggested Operating Range (AC or DC±)**

Diameter (mm)		2.6	3.2	4.0	5.0	6.0
Current (A)	F/H-fillet	70~110	110~150	130~190	170~240	230~300
	V/OH	40~70	60~120	110~160	-	-