

Covered Electrodes

K-8010G

For 560MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 46 0 C 22	JIS Z 3211	: E5510-G
EN ISO 2560-B:2006	: E 55 10-G A		
AWS A5.5-06	: E8010-G		

Description

- Covering is high cellulose type for all positions welding of pipes, general light structural steels.
- This electrode is characterized by deeply penetrating, forceful, spray type arc.
- Readily removable, thin friable slag.
- Good mechanical properties and the weld metal meets requirement X-ray.
- 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
0.09	0.43	0.76	0.011	0.009	0.32	0.03	0.25	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 47	40	AW
EN ISO 2560-A	min. 460	530-680	min. 20			
Example	520	610	24			

* AW : As-Welded

Sizes available and recommended currents (DC +)

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

Approvals

JIS, CE