S-6027.LF

Type : High recovery Rutile

Conformances

AWS A5.1/ ASME SFA5.1 E6027
JIS Z3211 E4327
EN ISO 2560-A-E38 0 R 1 4
KR 3
ABS 3
LR 3,3G
BV 3
DNV·GL 3
NK KMW3

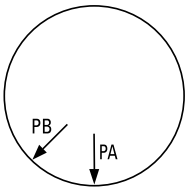
Applications

- General fabrication

Features

- High efficient fillet welding
- Low fume
- Good welding performance in manual and gravity welding

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter	Length	Standard	
mm (in)	mm (in)	packet 5kg(11lbs)	carton 20kg(44lbs)
4.0 (5/32)	550 (22)	√	
4.5 (11/64)	700 (28)	√	
5.0 (3/16)	700 (28)	√	
5.5 (7/32)	700 (28)	√	
6.0 (15/64)	700 (28)	√	
6.4 (1/4)	700 (28)	√	
7.0 (9/32)	700 (28)	√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.32	0.76	0.023	0.013

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
448 (65,100)	499 (72,500)	32.0	-30 (-22)	47 (35)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	4.0 (5/32)	4.5 (11/64)	5.0 (3/16)	5.5 (7/32)	6.0 (15/64)	6.4 (1/4)	7.0 (9/32)
Length mm (in)	550 (22)	550 (22) 700 (28)	700 (28)	700 (28)	700 (28)	700 (28)	700 (28)
F	140~180	170~210	180~230	210~250	240~290	260~310	280~330