

NK-68

Class of: AWS A5.1 E6013
JIS Z 3211 D4313

For Mild Steel

DESCRIPTION

NK-68 is a high titania type electrode for manual metal arc welding designed with excellent welding performances. It has arc stability, easy slag removal, low spatter and fumes, and smooth bead appearance. It is suitable for welding of steel sheets.

APPLICATIONS

All types of light gauge mild steel, fabrications, shipbuilding, pipes, machinery manufacturing and other wide range of mild steel structures.

INSTRUCTIONS FOR WELDING

1. Dry the electrodes at 80°C ~ 100°C for 30 ~ 60 minutes before use.
2. Choose the welding current within the suitable welding current range.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	S	P	Mn
0.08	0.24	0.014	0.016	0.40

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Point	Tensile Strength	Elongation
425 N/mm ² 43.3 kgf/mm ²	500 N/mm ² 51.0 kgf/mm ²	26.7%

RECOMMENDED CURRENTS: (AC or DCEP or DCEN)

Size (mm)	Diameter	2.6	3.2	4.0	5.0
Length		350	350	400	400
Current Range (Amp.)		60 ~ 110	80 ~ 140	120 ~ 190	170 ~ 210