

NK-88

For Welding Class Mild Steel

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

DESCRIPTION

NK-88 is a high titania type covered electrode which designed with high workability, slag removal, and easy for tack weld.

APPLICATIONS

General-purpose fabrication and structures of steel sheets, vehicles, buildings, vessels, machinery-manufacture and various structures of mild steel.

INSTRUCTIONS FOR WELDING

1. Dry the electrodes at 80 ~ 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
0.06	0.2	0.012	0.015	0.45

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength	Tensile Strength	Elongation
420 N/mm ² 43 kgf/mm ²	490 N/mm ² 50 kgf/mm ²	25 %

RECOMMENDED CURRENTS: (AC or DCEP or DCEN)

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