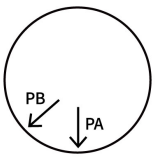
S-6027.LF

Classification

AWS A5.1/ASME SFA-5.1 E6027
JIS Z 3211 E4327
EN ISO 2560-A E38 0 R 1 4
KS D7004 E4327

Welding Positions



Features

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

Polarity

AC or DC ±

Application Areas

- General fabrication

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.32	0.78	0.023	0.009

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
401(58)	493(71)	30	-30(-20)	47(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
4.0(5/32)	550(22)	140-180	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.5(11/64)	550(22)/700(28)	170-210	
5.0(3/16)	700(28)	180-230	
5.5(7/32)	700(28)	210-250	
6.0(15/64)	700(28)	240-290	
6.4(1/4)	700(28)	260-310	
7.0(9/32)	700(28)	280-330	