

THJ506

Basic-potassium Type Electrode

AWS A5.1 E7016
ISO 2560-B-E4916 A
GB/T 5117 E5016

Applications:

It is suitable for the welding of carbon steel and low alloy steel structure, such as Gr.50, and so on.

Characteristics:

THJ506 is basic potassium type electrode with low hydrogen. Both AC & DC can be used and can be weld for all-position. It have excellent welding performance as good arc stiffness, little spatter, easy slag removal etc., and perfect mechanical properties of deposited metal.

Attention:

1. The electrode must be re-dry by 350℃-380℃ for 1 hour before welding.
2. The rust, oil, water and other impurities of the weld area must be removed before welding.

Chemical Composition of All Weld Metal:

(Wt. %)

Items	C	Mn	Si	S	P	Ni	Cr	Mo	V
Requirements	≤0.10	0.85-1.40	≤0.65	≤0.030	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08
Typical Results	0.07	1.10	0.35	0.012	0.018	0.030	0.035	0.005	0.004

Mechanical Properties of All Weld Metal:

Items	Rm/MPa	Rel/Rp _{0.2} /MPa	A/%	KV ₂ (-30℃) /J
Requirements	490-660	≥400	≥22	≥80
Typical Results	590	510	30	160

X-ray Radiographic Inspection:

Level I

Typical Operating Procedures: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0	5.8
Length (mm)	300	300	350	400	400	400
Current (A)	40-70	60-90	80-130	140-190	180-230	240-280

Classification of Society Certification:

Ship Inspection Agency	ABS	BV	CCS	DNV
Recognition Level	3YH10	3YHH	3YH10	3YH10
Ship Inspection Agency	LR	NK	KR	---
Recognition Level	3YmH15	KMW53H10	3YH10	---

Welding Positions:

