

S-6027.LF

TYPE : High recovery Rutile

AWS A5.1 / ASME SFA5.1 E6027

JIS Z3211 E4327

EN ISO 2560-A - E38 3 R 1 4

Applications

S-6027.LF is a low fume type electrode for highly efficient fillet welding, horizontal and flat fillet welding of ships, buildings, bridges.

Characteristics on Usage

S-6027.LF is an iron powder oxide type electrode. Fume generation is about 30~50% less than conventional electrodes. S-6027.LF has an excellent usability when used for manual welding, Gravity and auto-contact welding. Resistance to undercuts is good even in case of welding zinc-rich-painted plate or joint having gap.

Notes on Usage

- ① In case of manual welding, operate by contact welding.
- ② In case of gravity welding, the optimum speed ratio is 1.2~1.5.
- ③ Dry the electrodes at 70~100°C (158~212°F) for 30~60 minutes before use.

Welding Position



1G 2F
(PA) (PB)

Current

AC or DC +

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/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
448 (65,100)	499 (72,500)	32.0	-30 (-22)	47 (35)

Approval

KR, ABS, LR, BV, DNV, GL, NK

I Packing

Packet 10 kg (22 lbs)
Carton 10 kg (22 lbs) × 2 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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
GW	150~180	160~200	180~240	210~260	230~290	250~310	280~330