B-14 FAMILIARC™

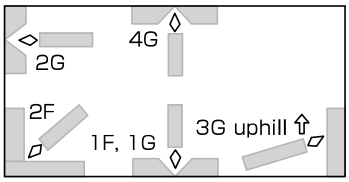
Stick electrode

Features:
- Suitable for butt and fillet welding of thin and medium-thick plates (up to 20mm)
- Excellent usability

Classification: AWS A5.1 E6019

Redrying conditions: 70~100℃x0.5~1h
Identification color: 1st Pale brown
Polarity: AC, DCEP, DCEN

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	20	170W, 120H, 380L
3.2	400	5	20	35	170W, 120H, 430L
4.0	450	5	20	62	170W, 120H, 480L
5.0	450	5	20	94	170W, 120H, 480L
6.0	450	5	20	141	170W, 120H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.10	0.20
Si	0.10	1.00
Mn	0.43	1.20
P	0.015	0.035
S	0.007	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	0.01	0.08

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1G, 1F, 2G, 2F	3G uphill, 4G
2.6	55~90	45~75
3.2	85~140	60~120
4.0	130~190	100~160
5.0	180~260	135~210
6.0	240~310	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	410	331min.
TS (MPa)	460	414min.
El on 4d (%)	32	22min.
IV -18℃ (J)	82	27min.

Approvals

ABS	3
LR	3m
DNV	3
BV	3
NK [a)]	KMW3
CR	3

Note: [a)] AC