

S-4303.T

Type : Lime-Titania

Conformances

JIS Z3211 E4303

EN ISO 2560-A-E38 0 RA 1 2

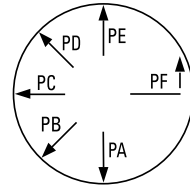
Applications

- General fabrication
- Automotive
- Machinery
- Bridges & Construction

Features

- Suitable for butt and fillet welding of thin plates
- Good restriking properties and high welding efficiency
- Suitable for tack welding
- Good mechanical properties

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter	Length	Standard	
		packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.16	0.48	0.019	0.014

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)
436 (63,300)	489 (71,000)	28.9	0 (32)	98 (73)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F & HF	65~100	100~140	140~190	200~250	250~330
V-up, OH	50~90	80~130	110~170	140~210	-