

S-7048.V

Type : Basic

Conformances

AWS A5.1/ ASME SFA5.1 E7048
 JIS Z3211 E4948
 EN ISO 2560-A-E42 3 B 3 5
 KR 3H10, 3YH10
 ABS 3H10, 3Y
 LR 3, 3YH15
 BV 3, 3YHH
 DNV-GL 3YH10
 NK KMW53HH

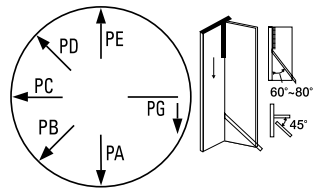
Applications

- Heavy steel fabrication
- Automotive
- Machinery

Features

- Suitable for tack welding
- Good at vertical down
- Good restriking
- Good bead appearance
- Easy to remove slag

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°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)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.54	1.05	0.011	0.009

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)
473 (68,700)	564 (81,900)	30.8	-30 (-22)	68 (50)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	4.5 (11/64)	5.0 (3/16)
Length mm (in)	400 (16)	450 (18)	450 (18)	450 (18)
F, V-down	100~160	140~210	180~240	220~270