

Classifications

EN ISO 2560-A:2006	: E 38 0 RB 12	KS D 7004	: E4303
EN ISO 2560-B:2006	: E 43 03 A U	JIS Z 3211	: E4303

Description

- Covering is lime titania type for welding of cars, other vehicles, light structural steels and pedestrian bridges.
- High welding efficiency and restriking property.
- Suitable for tack welding and intermittent welding.
- Excellent slag removal.
- Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.24	0.40	0.017	0.016	0.01	0.02	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
JIS Z 3211	min. 330	min. 430	min. 20	≥ 27		
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 47		
Example	420	530	32	100	60	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +, -)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	65~100 50~90	100~140 80~130	140~190 110~170	200~260 140~210	250~330 -

Approvals

ABS	DNV	GL	KR	LR	NK
3,D4303	3	3	3	3m	KMW3

* Others : KS, JIS, CE