

S-4303.V

Type : Lime-Titania

Conformances

JIS	Z3211 E4303
EN	ISO 2560-A-E38 2 RA 1 2
KR	3
ABS	3
LR	3
BV	3
DNV-GL	3
NK	KMW3

Applications

- General fabrication
- Shipbuilding
- Automotive, Bridges & Construction

Features

- Suitable for butt and fillet welding of thin plates
- Good at vertical down
- Good at vertical up
- Good mechanical properties

Typical Chemical Composition of All-Weld Metal(%)

C	Si	Mn	P	S
0.06	0.15	0.47	0.021	0.012

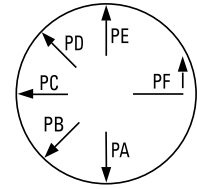
Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
422 (61,190)	454 (65,830)	33.6	0 (32) -20 (-4)	110 (81) 72 (53)

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	200~260	250~330
V-up, OH	50~90	80~130	110~170	140~210	-

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 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)	✓	

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX