

KT-42

Classification

AWS	A 5.1/A5.1M	-
JIS	Z3211	E4303
EN	2560-A	E35 0 RB 1 2
GB	T5117	E4303

Type of coating : Lime titania type

Applications and Features

- (1) Suitable for butt or fillet welding of mild steel (thickness <25 mm), such as ship-buildings, light structures and vehicles and bridges.
- (2) Excellent mechanical properties, crack resistance and capable of X-ray quality welds.
- (3) Stable arc, easy control of weld puddle, low spatters, good penetration, good slag removal and bead appearance.

Welding position



Welding Instruction

Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.08	0.45	0.014	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
470	400	28	0	95
			-20	75

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/H-fillet	80~120	120~170	170~240	230~300
	V-up/OH	60~110	110~160	-	-