

Stick Electrode for Mild Steel

KT-7

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 spot welding of light structures, vehicles and construction structures.
- (2) The weld metal has excellent mechanic properties, good weldability, appropriate penetration and good crack resistance.
- (3) Stable arc, low spatter, good slag fluids, 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
0.07	0.18	0.45	0.015	0.012

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
470	420	29	0	85

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	-	-