

KT-403

Classification

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

Type of coating : Lime titania type

Applications and Features

- (1) Suitable for spot welding of steel structures and general vehicles.
- (2) Excellent mechanic properties and good crack resistance.
- (3) Stable arc, low spatters, good slag removal and bead appearance.
- (4) Appropriate penetration, easy control of weld puddle and arc is easy to re-start.

Welding position



Welding Instruction

Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.09	0.25	0.63	0.021	0.006

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation %	Charpy V-Notch	
			°C	J
484	434	29	0	95
			-20	68

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		2.6	3.2	4.0	5.0	6.0
Current (A)	F/H-fillet	70~110	110~150	130~190	170~240	230~300
	V/OH	40~70	60~120	110~160	-	-