

F-03

LIME TITANIA TYPE

JIS Z 3211 D4303
EN499 E 35 2 RB 12

Characteristics and Applications:

F-03 can be used in wider current range. The welding in all-position can be done with good crack resistance, good slag covering and high welding speed for medium plates (16mm thickness or less). F-03 is recommended for high pressure vessels, bridges, pipes, storage tanks, marine works, and general steel structures.

Notes on Usage:

1. Be sure to clean up the contaminations on the base metal to reduce welding defect.
2. It is highly recommended to dry the electrodes at 80-100°C for 30-60 minutes before use.
3. Apply proper currents to prevent X-Ray and mechanical properties from being worse.
4. When weld with weave method, the moving range should not exceed 3 times the wire dia.

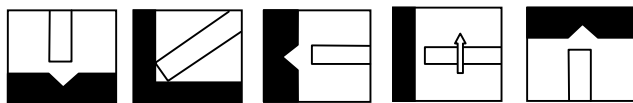
Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.080	0.45	0.15	0.015	0.01

Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	CVN 0°C J
395	460	30	98

Welding position



Sizes and recommended current range (AC or DC $\langle \pm \rangle$)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	450	450
Amps	F	65-100	100-140	140-180	190-240
	V&OH	50-90	80-110	100-160	150-200

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