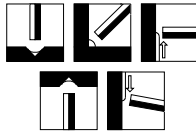


D-03	RUTILE - LIME - LOW SILICIOUS FLUX COATED MILD STEEL ELECTRODE WITH EXCELLENT VERTICAL UP AND OVERHEAD WELDING CHARACTERISTICS					DATA SHEET NO.					
						13					
SPECIFICATION	BS EN ISO 2560-B			JIS Z 3211							
CLASSIFICATION	E4303			D4303							
PRODUCT DESCRIPTION	<p>The flux is designed to produce a viscous slag with a wide solidification range which contains and refines the molten weld metal during positional welding.</p> <p>The flux is extruded onto a mild steel core wire with a blend of silicates that assures both strength of the coating while limiting moisture re-absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>The electrode welds with a soft stable arc and produces bright evenly rippled weld seams. Slag detachability is excellent. In addition for the slag to control large vertical up and overhead weld beads, it also assists in the achievement of full penetration root runs. Again vertical up when joint access is only available from one side.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>All positional welding of structural steels of the following and related steel specifications: Mild and medium carbon-manganese steels up to 15mm thick (for several circumstances can be used up to 25mm thickness) with a UTS of 500N/mm² max. Typical grades : BS 1449 plate and sheet, BS 4360 grades 43A and 43C, Lloyds A&D ship steel BS 4360 grade 50B Lloyds grades AH and DH, BS 3059 and BS 3601 grade 320-410 API 5L A-B and X42.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	V	Fe
	MIN	-	-	-	-	-	-	-	-	-	
	MAX	0.2	1.2	1.0	-	-	0.2	0.3	0.3	0.08	
	TYPICAL	0.1	0.5	0.2	0.02	0.02	0.05	0.05	0.1	0.01	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY		UNITS	MINIMUM	TYPICAL	OTHERS					
	Tensile strength		N/mm ²	420	540						
	0.2% Proof stress		N/mm ²	345	430						
	Elongation on 4d		%	22	30						
	Reduction of Area (RA)		%	-	70						
Impact energy 0°C		J	27	100							
WELDING AMPERAGE AC or DC	Ø (mm)	2.6	3.2	4.0	5.0						
	MIN	60	80	130	160						
	MAX	110	150	190	230						
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour										
RELATED PRODUCTS	Please contact our Technical Department for detail.										