Stick Electrode for Mild Steel					
	Classification				
		AWS	A 5.1/A5.1M	-	
KT-7		JIS	Z3211	E4303	
		EN	2560-A	E35 0 RB 1 2	
Type of coating :	Lime titania type	GB	T5117	E4303	

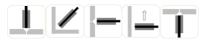
Applications and Features

- (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%)

с	Si	Mn	Р	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/mm²	N/mm²	%	°	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	-	-