

## KT-7

### Classification

|                |              |
|----------------|--------------|
| AWS A5.1/A5.1M | -            |
| JIS Z3211      | E4303        |
| EN ISO 2560-A  | E35 0 RB 1 2 |
| GB T5117       | E4303        |

Coating Type: Lime Titania

### Applications and Features

- (1) KT-7 is a lime titania type electrode for mild steel.
- (2) High current available, good crack resistance, and superior mechanical properties.
- (3) Easy strike and re-strike, stable arc, low spatter, good weld puddle fluidity, easy slag removal, deep penetration, and good bead appearance.
- (4) Ideal for tack welding and welding of light steel structure, automotive, and building structures.

### Welding Position



### Welding Instruction

Please see Appendix A

### Typical Weld Metal Composition (wt%)

| C    | Si   | Mn   | P     | S     |
|------|------|------|-------|-------|
| 0.07 | 0.18 | 0.45 | 0.015 | 0.012 |

### Typical Weld Metal Mechanical Properties

| Tensile strength  | Yield strength    | Elongation | Charpy V-Notch |    |
|-------------------|-------------------|------------|----------------|----|
| N/mm <sup>2</sup> | N/mm <sup>2</sup> | %          | °C             | J  |
| 470               | 420               | 29         | 0              | 85 |

### Available Sizes and Welding Parameters (AC/DC ±)

| Diameter (mm) |         | 3.2    | 4.0     | 5.0     | 6.0     |
|---------------|---------|--------|---------|---------|---------|
| Current (A)   | F/HF    | 80~120 | 120~170 | 170~240 | 230~300 |
|               | V-up/OH | 60~110 | 110~160 | -       | -       |