

# KT-403

Coating Type: Lime Titania

## Classification

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

## Applications and Features

- (1) KT-403 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     |
|------|------|------|-------|-------|
| 0.09 | 0.25 | 0.63 | 0.021 | 0.006 |

## 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  |
| 484               | 434               | 29         | 0              | 95 |
|                   |                   |            | -20            | 68 |

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

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