

S-4303.V

TYPE : Lime-Titania

JIS Z3211 E4303
EN ISO 2560-A - E35 2 RA 1 2

Applications

S-4303.V can be used for general purpose of welding carbon steel such as shipbuilding, rolling stock, buildings, bridges, light gauge shapes and vessels.

Characteristics on Usage

S-4303.V is a lime titania type electrode, whose usability is excellent in all position welding. It deposits smooth and flat weld metal of fine ripple mark with easy manipulation of the electrode, particularly in vertical up and overhead positions. Mechanical properties of all-weld metal are excellent next to that of low hydrogen type electrodes.

Notes on Usage

- ① Dry the electrodes at 70~100°C (158~212°F) for 30~60 minutes before use.
- ② As arc-restriking properties are not so good, it is suitable for intermittent welding.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC ±

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.15	0.47	0.021	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
433 (62,800)	470 (68,100)	33.6	0 (32) -20 (-4)	110 (81) 72 (53)

Approval

KR, ABS, LR, BV, DNV, GL, NK

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F,V-down	65~100	100~140	140~190	200~260	250~330
V-up, OH	50~90	80~130	110~170	140~210	-