

# F-03

LIME TITANIA TYPE

JIS Z 3211 E4303

## Characteristics and Applications:

F-03 can be used in wider current range. The welding in all-position can produce good crack resistance, good slag covering and high welding speed for medium/thin plates (16mm thickness or less). F-03 is recommended for vessels, bridges, pipes, storage tanks, marine works, and general steel structures.

## Notes on usage:

1. Be sure to clean up the contaminations on the base metal to reduce welding defect.
2. It is highly recommended to dry the electrodes at 80-100°C for 30-60 minutes before using.
3. Apply proper currents for good X-Ray and keeping mechanical properties from being worse.
4. The moving range should not exceed 3 times the wire dia when you are welding with weave method.

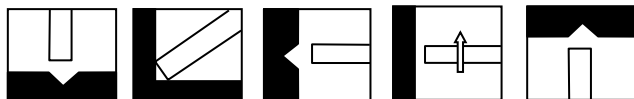
## Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S
JIS	≤0.20	≤1.20	≤1.00	-	-
Typical value	0.080	0.40	0.20	0.02	0.015

## Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) 0°C (32°F)
JIS	≥330	≥430	≥20	≥27(20)
Typical value	420(61)	490(71)	24	70(52)

## Welding position:



## Sizes and recommended current range (AC or DC <+>):

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	450	450
Amps	F	65-100	100-140	140-180	190-240
	V&OH	50-90	80-110	110-160	150-200

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