

As a result, the model is able to capture the effects of the different variables on the dependent variable. The model is also able to capture the effects of the different variables on the dependent variable. The model is also able to capture the effects of the different variables on the dependent variable.

1. Be sure to clean up the contamination on the base metal to reduce the cause of 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 to prevent X-Ray and mechanical properties from being worse.
4. When you weld with weave method, the moving range should not exceed 3 times the wire dia.

C	Mn	Si	P	S
0.095	0.45	0.08	0.02	0.015

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -20°C (0 °F)
430(62)	490(71)	27	50(37)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	450	450
Amps	F	50-100	80-140	130-180	170-240
	V&OH	40-70	60		

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