

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%):

		Si	P	S
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)
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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