

## COVERED ELECTRODES FOR MILD STEEL

### DESCRIPTION & APPLICATIONS :

- SM-03 is a high titania electrode type, suitable for thin or medium thickness base metal (16mm or less) on high welding speed.
- With stable arc, less spatter and nice bead appearance. Excellent re-start welding arc and good slag removability.
- It is used for shipbuilding, vehicle, bridges and steel structures.

### NOTE ON USAGE :

- It is recommended to dry the electrodes at 80~100°C for 30~60 minutes prior to use.
- Proper welding current is recommended to get good X-Ray soundness.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.082	0.39	0.18	0.018	0.009

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	EL %	IV 0°C J(Kgf-m)
421(43)	474(48.4)	30	87(8.9)

### SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(±)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amp.	F	100-140	140-180	180-240
	V & OH	70-110	100-160	140-200