

# S-4303.T

TYPE : Lime-Titania

JIS Z3211 E4303  
EN ISO 2560-A - E35 0 RA 1 2

SMW

## Applications

S-4303.T can be used for highly efficient welding in all positions such as vehicles, machinery, buildings and bridges.

## Characteristics on Usage

S-4303.T is a lime-titania type electrode used for welding in all positions. Iron powder contained in the coating ensures both good restriking properties and high welding efficiency.

It is suitable for tack welding and intermittent welding.

Mechanical properties of all-weld metal are also good, especially, impact values of all weld metal are better than those of ilmenite type electrodes.

## Notes on Usage

- ① Dry the electrodes at 70~100°C(158~212°F) for 30~60 minutes before use.
- ② Pay attention not to exceed the recommended range of currents.

## Welding Position

## Current



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

AC or DC ±

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.16	0.48	0.019	0.014

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
436 (63,300)	489 (71,000)	28.9	0 (32)	98 (73)

## Approval

## 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	65~100	100~140	140~190	200~250	250~330
V-up, OH	50~90	80~130	110~170	140~210	-