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Covered electrodes for mild steel and high tensile steel

Shikoku Welding Electrode Co., Ltd.

JIS Standard	Flux type	Trade Name	Diameter (mm φ)	Welding position	Applications	Characteristic on usage	Approved Class	Typical permissible substitute			
								KOBE STEEL	NSSW	JKW	NIKKO YOZAI
E4319U	Ilmenite type	No.8	2.6, 3.2, 4.0, 4.5, 5.0, 5.5, 6.0	All position	For all-position welding of general structures.	It is good, and bead appearance is also beautiful, and weldability and workability are excellent also in the mechanical performance.	NK(KMW3), ABS, LR, DNV, BV, CR, GL, KR	(B-10) (B-14)	G-200	KS-8 KS-7	
E4303U	Lime-titania type	SR-1	3.2, 4.0	All position	For all-position welding of general structures.	This welding rod is lime-titania type. It has welding workability, an X ray performance, and a good mechanical performance. It excels in the workability in a vertical and an overhead position, and a beautiful bead is obtained easily. Pipe welding shows good workability.	NK(KMW3), ABS, LR, DNV, BV, CR, GL, KR		NS-03Hi	KS-03R	
E4303		SR-2	2.0, 2.6, 3.2, 4.0, 5.0, 6.0	All position	For steel sheets and middle plate. For highly efficient welding of mild steel.	This welding rod is lime-titania type. Re-arcng is excellent. This rod is suitable for intermittenct welding, fillet welding and tack welding.	NK(KMW3), ABS, LR, BV,	TB-43 Z-44	S-03B	RV-03	LC-1 LC-3
E4313	High titanium oxide type	ST-10	2.6, 3.2, 4.0, 5.0, 6.0	All position	For welding of steel sheets and light structures.	This shows good usability in flat and horizontal fillet welding particularly. The arc is stable with little spatter, and the slag covering and its removability are good. This is suitable for welding steel sheets, because a lustrous and beautiful bead with shallow penetration can be obtained.	-	RB-26 B-33	S-13Z	KS-R	SK-100
E4340	Special type	SB-27	4.0, 4.5, 5.0, 5.5, 6.0, 7.0	Horizontal or flat fillet welding	For highly efficient horizontal or flat fillet welding of mild steel.	This is a welding only for flat and horizontal fillet welding. Good properties can be obtained in manual and Gravity welding. Re-arcng and the slag covering and its removability are good, resistibility to pits is good. Uniformity of the beads and resistibility to undercuts are good. Leg length of bead is beautiful.	NK(KMW3), ABS, LR, DNV, BV, CR, GL, KR	Z-43F	FI-120G EX-7 EX-4	KS-300(F)	
E4948H15	Low hydrogen type	SLV-16	3.2, 4.0, 4.5, 5.0, 5.5	All position (Vertical downward)	For vertical downward welding of mild and 490MPa high tensile steel.	This is a welding rod only for vertical downward welding. The slag covering and its removability are good, and a beautiful bead is obtained. Manipulate the electrode straight downward without weaving.	NK(KMW53H-H15), ABS, LR, DNV, BV, CR, GL, KR	LB-26V	-16V	KS-76V	LS-16V
E4940-G	Special type	SM-50G	4.0, 4.5, 5.0, 5.5, 6.0, 7.0	Horizontal or flat fillet welding	For horizontal or flat fillet welding of mild and 490MPa tensile steel.	This is a welding rod only for flat and horizontal fillet welding. Good properties can be obtained in manual and Gravity welding. The slag covering and its removability are good. Uniformity of the beads and resistibility to undercuts are good.	NK(KMW52), ABS, LR, DNV, BV, CR	LTB-50	EX-50G	KS-78	
E4948H15	Low hydrogen type	SL-50T	2.6, 3.2, 4.0	All position (Vertical downward)	For tack welding of mild and 490MPa high tensile steel.	This rod makes easier re-arcng, and the slag covering and its removability are good. Reliable tack weld can be performed. When a proper welding current is set, it makes all-position welding possible including vertical-down welding. There is also an H type which strengthened re-arcng.	NK(KMW53H-H15), ABS, LR, DNV, BV, CR, GL	LB-52T	TW-50	KS-76T RV-50T	
-		SL-50R	3.2, 4.0	All position	For repair welding of mild and 490MPa high tensile steel.	This is low hydrogen type covered electrode for repair welding. This shows good usability in flat and horizontal fillet welding. Its bead shape is flat.	NK(KMW53H-H15), DNV	LB-24			
E4928H15	Iron-powder low hydrogen type	SLH-52	4.0, 4.5, 5.0, 5.5, 6.0, 7.0	Horizontal or flat fillet welding	For horizontal or flat fillet welding of mild and 490MPa tensile steel.	This is a welding rod only for horizontal fillet welding. Workability is good, and the bead of good form is obtained. It can apply to fillet welding in important part. It can use to gravity welding.	NK(KMW53H-H15), ABS, LR, DNV, BV, GL	LT-B52A	LM-55G		
E4916H15	Low hydrogen type	SL-55	3.2, 4.0, 4.5, 5.0, 6.0	All position	For all-position welding of 490MPa and 540MPa high tensile steel.	Mechanical properties of the weld metal is excellent. The usabilitys such as slag removal and bead appearance are good, This can use welding for thick or high carbon steel.	NK(KMW53Y40-H10), ABS, LR, DNV, BV, CR, GL	LB-52	L-55	KS-76	