

Applications

S-7048.V can be used for vertical downward welding of high tensile steel. Such as vertical downward welding of ships, buildings and bridges.

Characteristics on Usage

S-7048.V is specifically designed for vertical downward welding. Slag is self peeling. Crack resistibility of weld metal is good.

Notes on Usage

- ① Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ② Remove rust, water, oil and paint from the surface to be welded.
- ③ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.

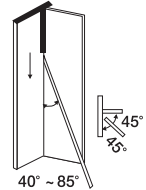
Welding Position



1G (PA) 2F (PB) 3D (PG)

Current

AC or DC +



Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.54	1.05	0.011	0.009

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
473 (68,700)	564 (81,900)	30.8	-30 (-22)	68 (50)

Approval

KR, ABS, LR, BV, DNV, GL, NK

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)	3.2 (1/8)	4.0 (5/32)	4.5 (11/64)	5.0 (3/16)
Length mm(in)	400 (16)	450 (18)	450 (18)	450 (18)
F, V-down	100~160	140~210	180~240	220~270