



ヤワタ 軟鋼用被覆アーク溶接棒

FT-51

ARC WELDING ELECTRODE
for MILD STEEL

スーパーアーク
SuperARC

Approved by: AMERICAN BUREAU OF SHIPPING
Licensed by: NIPPON STEEL WELDING
PRODUCTS & ENGINEERING CO., LTD. JAPAN

CLASSIFICATION
AWS A5.1 : E6013
JIS Z 3211 : E4313



FRONT
SIZE 21 X 29.7 CM

YAWATA FT-51 is a high rutile type electrode for all positions welding and assures easy operation even in vertical downward position. Spatters are less and bead appearance is beautiful.

Applications

Welding of mild steel sheet for ships, rolling-stocks, structures and finished welding of heavy structural works.

TYPICAL CHEMICAL COMPOSITION OF DEPOSITED METAL (%)				
C	Si	Mn	P	S
0.08	0.33	0.42	0.014	0.013

TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL			
TENSILE STRENGTH N/mm ² (kgf/mm ²)	YIELD STRENGTH N/mm ² (kgf/mm ²)	ELONGATION %	CHARPY 2V-NOTCH at 0°C, J (kgf.m)
510 (52)	460 (47)	28	60 (6.1)



BEAUTIFUL BEADS

DEEP PENETRATION

SELF-LIFTING SLAG

STRONG ARC

EXCELLENT
VERTICAL DOWN

GOOD FOR
TACK WELDING OR
STRUCTURAL WORKS

HOTLINE TECHNICAL SUPPORT
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WELDING POSITION
All Positions

SIZES & RECOMMENDED CURRENT RANGE (AC OR DC ±)					
DIAMETER/ LENGTH (mm)	2.0/300	2.6/350	3.2/350	4.0/400	5.0/400
PACKING SIZE (kg)	2.5/20	4/16 & 2/20	4/16 & 5/20	4/16 & 5/20	5/20
WELDING POSITION		CURRENT (A)			
F	30-70	50-100	60-130	110-170	150-220
V-Down	30-70	50-100	60-130	110-170	150-220
V. OH	30-70	50-100	60-130	100-150	130-190

DISCLAIMER 1. Various data of distinctive features such as welding materials, deposited metal, weld metal etc. shown in this catalogue are meant to explain the representative properties and performance of the products and are not to be taken as a guarantee except those which are specified clearly as "Specification". 2. In regards to the properties of welded structures, note that the results may be affected by the design of structures, chemical compositions of steel plates, construction methods, welding conditions, ability of constructor etc. 3. The company shall not take responsibility for damages caused by the misuse of the technical information written in this catalogue.

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