

FAMILIARC™

KOBE-30

Welding Electrode for Mild Steel



Application

FAMILIARC KOBE-30 is a high titania type covered welding electrode suitable for all position welding which make it possible to be vertical downward welding. It is suitable for welding steel sheet for example ship building, ship repair, oil storage, tank and general steel structures.

Features

- ◆ Smoother arc transfer
- ◆ Less spatter
- ◆ Slag removable
- ◆ Smoother bead appearance
- ◆ It is possible to be vertical downward welding

Deposition rate (g/min)



KOBE-30

Typical chemical composition of all weld-metal (%)

C	Si	Mn	P	S
0.09	0.28	0.39	0.011	0.014

Typical mechanical properties of all weld-metal

0.2% OS (MPa)	TS (MPa)	EI (%)
450	510	25

Available sizes and recommended welding current

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	400	400
Welding current (A)	F, HF, H, VD	45~95	60~120	105~170	150~220
	VU, OH	45~95	60~125	100~150	125~190

Notes on usage

If **FAMILIARC™ KOBE-30** absorbs too much moisture, that may cause increase of spattering, undercut and irregular bead appearance. Redrying the electrodes at 70~100 C for 30~60 minutes prior to use is recommended to improve these adverse effects by moisture pick up. Excessive high welding current should be avoided in order to minimize the spatter and obtain the best usability electrode.

DISCLAIMER

• Information in this booklet such as chemical compositions and mechanical properties is typical or example for explaining the features and performance of our products, and it does not guarantee otherwise specified.
 • Information contained herein is subject to change without notice. Please kindly contact KOBELCO for latest information

➤➤➤ For Technical Consultation, please contact **Technical Service.**

THAI KOBELCO WELDING CO.,LTD.

Head Office and Factory

500 Moo 4 Soi 1 Bangpoo Industrial Estate, Sukhumvit Road, Praeksa, Muang, Samutprakam 10280, Thailand
 Tel : (+66)-2-324-0588~91 , Fax : (+66)-2-324-0797
 Web site : <http://www.thaikobelco.com>

Bangkok Office

10th Fl., Sathorn Thani II Building, 92/23 North Sathorn Road. Silom, Bangrak, Bangkok 10500, Thailand
 Tel : (+66)-2-636-8650~2 , Fax : (+66)-2-636-8653



JQA-QM3667
JQA-EM5680