Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

INDOTHERME

CODIFICATION :

AWS : SFA 5.1 E7016
IS : 814 EB5426H_2X

CHARACTERISTICS AND APPLICATIONS :

A medium coated basic type hydrogen controlled electrode producing a tough, ductile weld metal for welding heavy sections in mild steel, medium high tensile steels, subjected to dynamic loading. Also suited for cast steels, difficult steels of unknown composition and for non-machinable deposits on cast iron. Typical applications include coaches, ships, heavy duty structures, earth moving machinery, rotary kiln shells, cast irons.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P
Percent	0.07	1.10	0.54	0.018	0.021

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength (J) at Minus 20°C	CVN Impact Strength (J) at Minus 30°C
558	477	28	60	30

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	6.3x450	5x450	4x450	3.15x450	2.5x350
Current Range (Amps)	240-320	190-250	140-200	90-140	70-100
Qty.(Pcs./Carton)	25	35	55	75	150

APPROVALS: BHEL, BIS, EIL, NTPC, PDIL

PRECAUTION:

1. Ensure the electrodes are dry. Redry the moist electrodes as per our standard recommended practice.