Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

SUPRATHERME (MOD)

CODIFICATION:

AWS : SFA 5.1 E7018
IS : 814 EB5426H_3JX

CHARACTERISTICS AND APPLICATIONS:

Basic coated, iron powder, hydrogen controlled, all conventional position electrode, produces radiographic quality welds, having excellent cracking resistance. The electrode ideally suited for welding carbon steels used in the construction of equipment subject to heavy dynamic load impact and severe service conditions in sour gas service.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	S	P
Percent	:	0.06	1.02	0.44	0.006	0.015

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 30°C (Joules)
515	416	30.0	100

CORROSION TEST : Passes corrosion test as per NACE standard TM-01-77-96(SSCC) and TM-02-84-96(HIC).

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Current Range (Amps)	:	270-320	200-250	150-190	100-140	70-100
Qty.(Pcs./Carton)	:	25	30	50	75	100

APPROVALS: EIL

HARDNESS OF WELD METAL : 200 HV5 Max.
DIFFUSIBLE HYDROGEN : Max.5ml/100gms of W.M.

PRECAUTION:

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