



SUPRATHERME-(SPL) MOD

CODIFICATION : AWS : SFA 5.1 E7018-1
IS : 814 EB5626H₃JX

CHARACTERISTICS AND APPLICATIONS :

Basic coated iron powder type, high yield, and hydrogen-controlled electrode. Easy to operate in all conventional welding positions. Radiographic quality welds having excellent cracking resistance. Ideally suited for welding carbon steels used in the construction of equipment subjected 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	Ni+Cr+Mo+V+Mn
Percent :	0.06	1.40	0.40	0.010	0.019	< 1.75

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at minus 45°C (Joules)
535	426	29.0	82.0

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

HARDNESS OF WELD METAL: 200 BHN max.

DIFFUSIBLE HYDROGEN: Max. 5ml/100 gms of weld metal

CURRENT AND PACKING DATA: AC/DC(+)

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

PRECAUTIONS:

1. Redry the moist electrodes at 250-300°C for one hour as per standard recommended practice.