50 YEARS 1966 - 2016

Estd. 1966
DH
sécheron
Complete Welding Support

SUPRATHERME

CODIFICATION :

AWS : SFA 5.1 E7018
IS : 814 EB5426H_3JX

CHARACTERISTICS AND APPLICATIONS :

A heavy coated low hydrogen, iron powder type electrode ideally suited for producing tough and ductile welds of radiographic quality in boilers, pressure vessels and heavy structures subjected to dynamic loading. The electrodes have a metal recovery of about 115%. Some typical applications include heavy structures subjected to dynamic loading and impact, highly restrained joints, coaches, wagons, penstocks, boilers, pressure vessels, earthmoving machines, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	S	P
Percent	0.06	1.02	0.44	0.022	0.022

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 30°C (Joules)
545	460	28	65

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	100-150	70-100
Qty.(Pcs./Carton)	25	50	70	100	150

APPROVALS: ABS, Adani Infra, BHEL, BIS, BV, CIB-MP, DNV, EIL, Indian Navy, IRS, L&T Power, LRA, NPCIL, NTPC, PDIL, Reliance (Engineering)

PRECAUTION:

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