Estd. 1966
DNH
sécheron
Complete Welding Support

# SUPRATHERME

**CODIFICATION :**

AWS : SFA 5.1 E7018
IS : 814 EB5426$H_3$JX
EN ISO : 2560-A E 42 3 B 3 2

## 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= 5d)% | 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, CE, CIB-MP, DNV, EIL, Indian Navy, IRS, L&T Power, LRA, NPCIL, NTPC, PDIL, Reliance (Engineering)

## PRECAUTION:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300°C for 2 hours.
2. Use short are, minimize heat input.