

SUPABASE / SUPABASE-X-PLUS

World Class E 7018 Electrodes



- All position electrodes.
- A basic type, Low Hydrogen, Iron Powder electrodes.
- Gives excellent arc stability, arc smoothness and easy slag removal.
- Electrodes gives weldmetal of radiographics quality.
- Consistency in performance batch after batch, welder friendly.
- Moisture / Hydrogen controlled.
- Approved by Leading agencies.



ADOR WELDING LIMITED Central Marketing Office

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SUPABASE

CLASSIFICATIONS

AWS A/SFA 5.1	E 7018
IS 814	EB 5426H ₃ JX
EN 499	E 42 3 B 42 H 10
DIN 1913	E 5144B 1026
BS 639	E 5144B 12024(H)

Coating Type: Basic Deposition Eff., %: ~115

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CHARACTERISTICS

A basic-type, low-hydrogen, iron-powder electrode with metal recovery of 115% approx. It gives excellent arc stability, arc smoothness and easy slag removal. It has exceptional all-positional operating characteristics giving X-ray quality welds even for pipe welding in 5G & 6G positions.

TYPICAL APPLICATIONS

Welding of storage tanks, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM SA-414/SA-414M Gr. C&D (P. No. 1) • Gr.55, Gr. 60 steels of SA-516/516M (P. No. 1), IS2002, 2062

WELD METAL CHEMISTRY, wt%

C	- 0.04 – 0.09	S	- 0.030 max.	Diffusible H ₂
Mn	- 0.80 – 1.60	P	- 0.030 max.	Content, ml/100gm
Si	- 0.35 – 0.70			<5

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	RA	CVN Impacts, J		Hardness, BHN
	MPa	MPa	(L=4Xd)	%	-20°C	-29°C	
AW	500-600	440-550	24 min.	45 min.	50-80	30-70	200 max.

AW : As-welded

APPROVALS

ABS	3YH5	NPCIL	E 7018
BV	3YHH	IBR	E 7018
DNV	3YH5	Toyo	E 7018
IRS	3H3YH		
LRS	3YMH15		
PDIL	E-7018		

CURRENT CONDITIONS: AC, DC (+)

6.3	5.0	4.0	3.2	2.5
230-310	180-240	140-180	100-130	60-90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

PACKING DATA

	6.3	5.0	4.0	3.2	2.5
Dia., mm	450	450	450	450	350
Length, mm	5.25	5.25	5.25	5.25	5.25
Wt. per carton, kgs	4	4	4	4	4
Cartons/ box	21	21	21	21	21
Wt. per box, kgs					

SUPABASE X PLUS

CLASSIFICATIONS

AWS A/SFA 5.1	E 7018
IS 814	EB5426H ₃ JX
EN 499	E 42 3 B 42 H 10
DIN 1913	E 5144B 1026
BS 639	E 5144B 12024(H)

COATING TYPE: Basic DEPOSITION EFF., %: ~115

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. It gives excellent arc stability, arc smoothness and very easy slag removal. It has exceptional all-positional operating characteristics giving X-ray quality welds even for pipe welding in 5G & 6G positions.

TYPICAL APPLICATIONS

Welding of storage tanks, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM SA-414/SA-414M Gr. C&D (P. No. 1) • Gr.55, Gr. 60 steels of SA-516/516M (P. No. 1), IS2002, 2062

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AW : As-welded

APPROVALS

ABS	Gr. 3Y3H10	NPCIL	E 7018
BV	Gr. 3YHH	IBR	E 7018
DNV	Gr. 3YH5	Toyo	E 7018
IRS	Gr. 3H3YH	BIS	IS 814-91 EB5426H ₃ JX
LRS	Gr. 3YMH15	RDSO	A4 & B2
GL	Gr. 3YH5	M & N DASTUR & CO.	

CURRENT CONDITIONS: AC, DC (+)

6.3	5.0	4.0	3.2	2.5
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India's Welding Power House

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