

SUPERBOND-SERIES

SUPERBOND

SUPERBOND S

SUPERBOND SS

All Position E 6013 MSGP Electrodes



- Rutile coated electrodes, easy to operate in all position.
- Operates with quiet arc and smooth bead with fine ripples.
- Gives medium penetration, least spatter and easily detachable slag.
- Easy arc strike & re-strike.
- Superior mechanical properties and ideal for radiographic quality.
- Approved by leading agencies.



ADOR WELDING LIMITED
Central Marketing Office

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SUPERBOND

CLASSIFICATIONS

AWS A/SFA 5.1 E 6013 **DIN 1913** E 4322R 312
IS 814 ER 4212 X **BS 639** E 422R11

COATING TYPE: Rutile
COATING FACTOR: Medium **IDENTIFICATION:** Brand Printed

CHARACTERISTICS

An electrode of structural importance. It gives excellent arc stability, fine ripples and very easy slag removal. It has exceptional all-positional operating characteristics, especially in vertical down, resulting in X-ray quality welds.

TYPICAL APPLICATIONS

Steel structures and tanks, Truck frames and bodies, Ships, pipelines, bridges etc. Suitable for joining steels like A,B,C,D grades of ASTM SA-283 (P. No. 1)

APPROVALS

ABS Gr. 2 **BIS** IS814 ER4212X
DNV Gr. 2 **IBR** E6013
LRS Gr. 2 **Toyo** E6013
BV Gr. 2 **IRS** Gr. 2

M & N DASTUR AND CO. PDIL - E-6013
CURRENT CONDITIONS AC, DC (-)
 6.3 5.0 4.0 3.2 2.5
 230- 180- 140- 100- 60-
 310 240 180 130 90

WELDING POSITIONS

F, H, V-down, V-up, OH

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110°C for ½ hr

WELD METAL CHEMISTRY, wt%

C - 0.10 Max. Mn - 0.60 Max. Si - 0.28 Max. S - 0.03 max. P - 0.03 max.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	RA %	CVN Impacts,J 0°C	Hardness BHN
AW	460-550	370-480	22-28	50 min.	50 min.	200 max.

AW : As-welded

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					

SUPERBOND S

CLASSIFICATIONS

AWS A/SFA 5.1 E 6013 **DIN 1913** E4322R322
IS 814 ER 4222X **BS 639** 4322R21
EN 499 E380RC11

COATING TYPE: Rutile
COATING FACTOR: Medium **IDENTIFICATION:** Brand Printed

CHARACTERISTICS

A rutile-type, all-position electrode of outstanding quality. The electrode produces a smooth, clean deposit with very little spatter loss and easily detachable slag. Ideal for radiographic quality welds on boilers, tubes etc.

TYPICAL APPLICATIONS

Storage tanks, shipbuilding, bridges, boiler tubes, pressure vessels, railway wagons, etc. Suitable for joining steels like ASTM SA-36/SA-36M (P.No. 1), A, B, C, D grades of SA-283/SA-283M (P.No. 1), A, B, C grades of SA-285/SA-285M (P.No. 1), A, B grades of SA-414/SA-414M (P.No. 1)

APPROVALS

ABS Gr. 2 **LRS** Gr. 2 **KPG** E 6013
BV Gr. 2 **GL** Gr. 2 **BIS** IS 814 ER 4222X
DNV Gr. 2 **IBR** E 6013 **NPICIL** E-6013
IRS Gr. 2 **Toyo** E 6013 **PDIL** E-6013

CURRENT CONDITIONS AC, DC (-)
 6.3 5.0 4.0 3.2 2.5 1.6
 250- 180- 140- 100- 60- 30-
 330 250 190 140 90 60 50

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110°C for ½ hr.

WELD METAL CHEMISTRY, wt%

C - 0.10 Max. Mn - 0.60 Max. Si - 0.25 Max. S - 0.030 max. P - 0.030 max.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	RA %	CVN Impacts,J 0°C	Hardness BHN
AW	460-550	370-480	22-30	50-75	50 min.	200 max.

AW : As-welded

PACKING DATA

	6.3	5.0	4.0	3.2	2.5	2.0	1.6
Dia.,mm	450	450	450	450	350	300	250
Length,mm	5.25	5.25	5.25	5.25	5.25	5.25	5.25
Wt. per carton, kgs	4	4	4	4	4	4	4
Cartons/ box	21	21	21	21	21	21	21
Wt. per box, kgs							

SUPERBOND SS

CLASSIFICATIONS

AWS A/SFA 5.1 E 6013 **BS 639** E 4322RR21
IS 814 ERR 4222X **DIN 1913** E 4322RR622

COATING TYPE: Rutile
COATING FACTOR: Heavy **IDENTIFICATION:** Brand Printed

CHARACTERISTICS

An electrode for major structural work where radiographic quality at high welding speed is desired. The electrode produces a smooth, clean deposit with very little spatter loss and easily detachable slag. Can be used as touch type electrode.

TYPICAL APPLICATIONS

Storage tanks, locomotive fireboxes, pressure vessels, railway coach panels, fine steel furniture, scooter frames, automobile bodies, boilers and wherever strength combined with streamlined finish is necessary. Best suited for bridging wide rootgaps • Suitable for joining steels conforming to ASTM specification: • SA-36/SA-36M (P.No. 1) • A, B, C, D grades of SA-283/SA-283M (P.No. 1) • A, B, C grades of SA-285/SA-285M (P.No. 1) • A, B grades of SA-414/SA-414M (P.No. 1)

APPROVALS

ABS Gr. 2 **BIS** IS 814 ERR4222X
DNV Gr. 2 **IBR** E6013
LRS Gr. 2 **Toyo** E6013
BV Gr. 2 **IRS** Gr. 2 **PDIL** E-6013

CURRENT CONDITIONS AC, DC (-)
 6.3 5.0 4.0 3.2 2.5 2.0
 250- 190- 140- 100- 60- 40-
 330 250 190 140 90 60

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110° C for ½ hr.

WELD METAL CHEMISTRY, wt%

C - 0.10 Max. Mn - 0.60 Max. Si - 0.25 Max. S - 0.03 max. P - 0.03 max.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	RA %	CVN Impacts,J 0°C	Hardness, BHN
AW	460-550	370-480	23-30	50-75	50-80	200 max.

AW : As-welded

PACKING DATA

	6.3	5.0	4.0	3.2	2.5	2.0
Dia.,mm	450	450	450	450	350	300
Length,mm	5.25	5.25	5.25	5.25	5.25	5.25
Wt. per carton, kgs	4	4	4	4	4	4
Cartons/ box	21	21	21	21	21	21
Wt. per box, kgs						

India's Welding Power House



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