ador
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X BOND

C-Mn STEEL (Low Hydrogen)

Welding Electrode for Structural Welding Application

CLASSIFICATION : ISO 2560-A	AWS A/SFA 5.1	APPROVALS :
E 42 2 B 32	E 7018	ABS/LRA/IBR/MND

KEY FEATURES :

- Basic coated electrode
- Low hydrogen iron powder type
- Tough and ductile weld
- Radiographic weld deposit
- Deposition efficiency upto 110-115%
- All position capability
- Pipe welding in 5G and 6G positions

WELDING POSITION : 

AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Structural welding
- Storage tanks
- Boilers, Pressure vessels
- Bridges, Pipes
- Joining steel ASTM SA 414/414M Gr.C/D/E, SA 516/516M Gr.55/60

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.07	1.0	0.5	0.02	0.02
Specification	0.15 max	1.6 max	0.75 max	0.035 max	0.035 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	525	440	26	55
Specification		490 min	400 min	22 min	27 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	231	4	22
3.15 x 450	100-130	111	4	45
4.0 x 450	140-180	75	4	66
5.0 x 450	180-240	50	4	98

EQUIVALENT: GMAW wire: Automig-70S-6 FCAW wire: Automig–FC-71T-1, Automig-FC-121