



## SUPABASE

C-Mn STEEL (Low Hydrogen)



Special Welding Electrode for Pressure Vessels and Bridges

**CLASSIFICATION : ISO 2560-A**

**AWS A/SFA 5.1**

**IS 814**

**APPROVALS :**

E 42 3 B32 H5

E 7018

E B5426H<sub>3</sub>JX

ABS/BV/DNV/IRS/LRA/  
IBR/BIS/NTPC/BHEL

### KEY FEATURES :

- Basic type iron powder electrode
- Metal recovery approx. 115%
- All position capability
- Radiographic weld deposit
- Suitable for pipe welding in 5G & 6G positions

**WELDING POSITION :**



**AC (70 OCV)/ DCEP**

### TYPICAL APPLICATIONS :

- Pressure vessels, Pipes
- Storage tanks
- Bridges, Heavy structures
- Joining steel of ASTM SA 414/414M Gr.C/D, SA 516/516M Gr.55/60, IS 2002, IS 2062

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	1.1	0.4	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 :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact , J</b>	
					<b>-20°C</b>	<b>-30°C</b>
Typical	As Welded	540	470	26	66	48
Specification		490 min	400 min	22 min	50-80	30-70

**Diffusible H<sub>2</sub> Content: <5 ml/100 gm**

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	225	4	22
3.15 x 450	100-130	110	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**