

### CLASSIFICATION:

ISO 2560-A  
E 42 3 B32 H5

IS 814  
E B5426H<sub>3</sub>JX

### 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

**APPROVALS:** ABS/BV/LRA/IBR/BIS/NTPC/BHEL/CE

### 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

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

C	Mn	Si
0.06	1.1	0.4


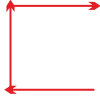
### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact
					-30°C, J
Typical	As Welded	540	470	26	60
Specification		490 min	400 min	22 min	47 min

**Hardness, 3 Layer:** - 200BHN max

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

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 <b>AC (70 OCV)/ DCEP</b> All Positions Except Vertical Down: 
3.15 x 450	100-130	
4.0 x 450	140-180	
5.0 x 450	180-240	

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

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing

### EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 70S-3	Tigfil 70S-2	Automig FC 71T-5	Automelt B71	Automelt EM12K
Automig 70S-6	Tigfil 70S-3		Automelt B31	Automelt EH14
	Tigfil 70S-6			