



SUPABASE

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 **E7018**

CLASSIFICATION:

ISO 2560-A
E 42 3 B32 H5

IS 814
EB5426H₃JX

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 H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

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

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

EQUIVALENT:

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