



# SUPABASE X PLUS

C-Mn STEEL (Low Hydrogen)



Covered Electrode for 500 MPa High Tensile Strength Steel

**CLASSIFICATION : ISO 2560-A**

**AWS A/SFA 5.1**

**IS 814**

**APPROVALS :**

E 42 3 B 32 H5

E 7018

E B5426H<sub>3</sub>JX

ABS/BV/DNV/IRS/GL/LRA  
/IBR/BIS/NPCIL/MND

## KEY FEATURES :

- Basic coated electrode
- Low hydrogen iron powder type
- Medium penetration
- High deposition rate
- Radiographic weld quality
- All position capability

## WELDING POSITION :



**AC (70 OCV)/ DCEP**

## TYPICAL APPLICATIONS :

- Boilers, Pressure vessels
- Heavy structures subject to dynamic loading
- Ship building, Storage tanks
- Bridges, Pipe lines, Penstocks
- Joining IS 2002, 2062 steels

**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	0.05	1.1	0.5	0.015	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 at</b>	
					<b>-20°C</b>	<b>-30°C</b>
Typical	As Welded	555	480	26	67	48
Specification		490 min	400 min	22 min	50-80	30-70

**Hardness, 3 Layer: 160-200 BHN**

**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**