



SUPABASE 60

C-Mn STEEL (Low Hydrogen)



Covered Electrode For 450 MPa High Tensile Strength Steel

CLASSIFICATION : ISO 2560-A

E 38 3 B32 H5

KEY FEATURES :

- Basic coated electrode
- Low hydrogen iron powder type
- Medium penetration
- High deposition rate
- Radiographic weld quality
- All position welding except vertical down

WELDING POSITION :



AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Repairs and tie-ins in oil and gas transport pipe lines
- Heavy structures subject to dynamic loading
- Ship building, Storage tanks
- Bridges, Pipe lines, Penstocks
- Joining IS 2002, 2062 steels

REDRYING CONDITION : 300°C for 1 hr (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.03 max	0.6 max	0.4 max	0.015	0.025 max
Specification	0.2 max	1.2 max	1.0 max	-	-

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at
					-30°C
Typical	As Welded	430 min	330 min	22 min	27 min
Specification		430 min	330 min	22 min	22 min

Hardness, 3 Layer: 200 BHN max

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Carton/Box
2.5 x 350	60-90	4
3.15 x 450	100-130	4
4.0 x 450	140-180	4
5.0 x 450	180-240	4