

SUPERBOND S

CLASSIFICATIONS

AWS A/SFA 5.1 E6013
IS 814 E R4222X

IDENTIFICATION: Name Printed

CHARACTERISTICS

A rutile-type, all-position electrode of outstanding quality. The electrode produces a smooth, clean deposit with very little spatter loss and easily detachable slag. Ideal for radiographic quality welds on boilers, tubes, etc.

TYPICAL APPLICATIONS

Storage tanks, shipbuilding, bridges, boiler tubes, pressure vessels, railway wagons, etc. Suitable for joining steels like ASTM SA-36/SA-36M (P.No. 1), A, B, C, D grades of SA-283/SA-283M (P.No. 1), A, B, C grades of SA-285/SA-285M (P.No. 1), A, B grades of SA-414/SA-414M (P.No. 1)

WELD METAL CHEMISTRY, (%)

C - 0.10 max. S - 0.030 max.
Mn - 0.60 max. P - 0.030 max.
Si - 0.25 max.

MECHANICAL PROPERTIES- ALL-WELD

| Condition | UTS MPa | YS MPa | % Elong. (L=4Xd) | CVN Impacts, J 0°C |
|-----------|------------|-----------|---------------------|-----------------------|
| As-welded | 460-550 | 370-480 | 22-28 | 50 min. |

APPROVALS

ABS Gr. 2 **LRA** 2m, NR **KPG** E 6013 **RDSO - A2**
BV Gr. 2 **GL** Gr .2 **BIS** IS 814 E R4222X
DNV Gr. 2 **IBR** E 6013 **SONCAP**
IRS Gr. 2 **Toyo** E 6013 **MND**

CURRENT CONDITIONS: AC, DC (-)

| | | | | | |
|---------|---------|---------|-------|-------|-------|
| 5.0 | 4.0 | 3.2 | 2.5 | 2.0 | 1.6 |
| 180-250 | 140-190 | 100-140 | 60-90 | 40-60 | 30-50 |

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

None. Moist electrodes may be reconditioned at 100-110°C for ½ hr.

PACKING DATA

| | | | | | | |
|----------------------------|-----|-----|-----|------|------|------|
| Dia., mm | 5.0 | 4.0 | 3.2 | 2.5 | 2.0 | 1.6 |
| Length, mm | 450 | 450 | 450 | 350 | 300 | 250 |
| Pcs per carton, Nos | 55 | 84 | 129 | 277 | 505 | 942 |
| Cartons / box | 4 | 4 | 4 | 4 | 4 | 4 |
| Pcs per box, Nos | 220 | 336 | 516 | 1108 | 2020 | 3768 |
| Approx. Wt. of 1000 pcs,kg | 89 | 59 | 39 | 18 | 10 | 5 |



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ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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