

# SUPERBOND SS

## CLASSIFICATIONS

**AWS A/SFA 5.1** E6013  
**IS 814** E RR4222X

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An electrode for major structural work where radiographic quality at high welding speed is desired. The electrode produces a smooth, clean deposit with very little spatter loss and easily detachable slag. Can be used as touch type electrode.

## TYPICAL APPLICATIONS

Storage tanks, locomotive fireboxes, pressure vessels, railway coach panels, fine steel furniture, scooter frames, automobile bodies, boilers and wherever strength combined with streamlined finish is necessary. Best suited for bridging wide root gaps • Suitable for joining steels conforming • ASSTM specification. 1) • SA -36/SA36M (P.No. 1) • A, B, C, D grades of SA-283/SA283M (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 - 0.03 max.  
 Mn - 0.60 max. P - 0.03 max.  
 Si - 0.30 max.

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J
	MPa	MPa	( L=4Xd)	0°C
As-welded	460-550	370-480	23-30	50-80

## APPROVALS

<b>ABS</b>	Gr. 2	<b>BIS</b>	IS 814 ERR 4222X
<b>DNV</b>	Gr. 2	<b>IBR</b>	E 6013
<b>LRA</b>	2m, NR	<b>Toyo</b>	E 6013
<b>BV</b>	Gr. 2	<b>IRS</b>	Gr. 2

## CURRENT CONDITIONS: AC, DC (-)

5.0	4.0	3.2	2.5	2.0
190-250	140-190	100-140	60-90	40-60

## 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
Length, mm	450	450	450	350	300
Pcs per carton, Nos	48	73	114	244	495
Cartons / box	4	4	4	4	4
Pcs per box, Nos	192	292	456	976	1980
Approx. Wt. of 1000 pcs,kg	102	68	44	20	10



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