

SUPERBOND

CLASSIFICATIONS

AWS A/SFA 5.1 E6013
IS 814 E R4212X

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode of structural importance. It gives excellent arc stability, fine ripples and very easy slag removal. It has exceptional all-positional operating characteristics, especially in vertical down, resulting in X-ray quality welds.

TYPICAL APPLICATIONS

Steel structures and tanks, Truck frames and bodies, Ships, pipelines, bridges etc. Suitable for joining steels like A,B,C,D grades of ASTM SA-283 (P. No. 1)

WELD METAL CHEMISTRY, (%)

C - 0.10 Max.	S - 0.03 max.
Mn - 0.60 Max.	P - 0.03 max.
Si - 0.28 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
DNV Gr. 2
LRA 2m, NR
BV Gr. 2
MND

BIS IS814 E R4212X
IBR E6013
Toyo E6013
IRS Gr. 2

CURRENT CONDITIONS: AC, DC (-)

5.0	4.0	3.2	2.5
180-240	140-180	100-130	60-90

WELDING POSITIONS

F, H, V-down, V-up, OH

REDRYING CONDITIONS

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

PACKING DATA

	5.0	4.0	3.2	3.2	2.5
Dia., mm	450	450	450	350	350
Length, mm	58	90	139	171	296
Pcs per carton, Nos	4	4	4	4	4
Cartons / box	232	360	556	684	1184
Pcs per box, Nos	85	55	36	29	17
Approx. Wt. of 1000 pcs,kg					



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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