

# SUPABASE X PLUS

## CLASSIFICATIONS

<b>AWS A/SFA 5.1</b>	E7018
<b>IS 814</b>	E B5426H, JX
<b>BS 639</b>	E 5144B 12024(H)

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A low-hydrogen, iron-powder electrode. It gives excellent arc stability, arc smoothness and very easy slag removal. It has exceptional all-positional operating characteristics giving X-ray quality welds even for pipe welding in 5G & 6G, 6GR positions.

## TYPICAL APPLICATIONS

Welding of storage tanks, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM S-414M GrA-414/SA. C&D (P. No. 1) • Gr.55, Gr. 60 steels of S-516/516M (PA. No. 1), IS2002, 2062

### WELD METAL CHEMISTRY, (%)

C	- 0.04 - 0.09	S	- 0.030 max.	Diffusible H <sub>2</sub>
Mn	- 0.80 - 1.60	P	- 0.030 max.	Content, <5 ml/100gm
Si	- 0.35 - 0.70			

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J	
	MPa	MPa	( L=4Xd)	-20 <sup>0</sup> C	-30 <sup>0</sup> C
As-welded	500-600	440-550	24-30	50-80	30-70

## APPROVALS

<b>ABS</b>	3YH5	<b>NPCIL</b>	E 7018
<b>BV</b>	3YH5, 3YHH	<b>IBR</b>	E 7018
<b>DNV</b>	3YH5	<b>Toyo</b>	E 7018
<b>IRS</b>	3YH, 3YHHH, 3HHH	<b>BIS</b>	E B5426H, JX
<b>LRA</b>	3, 3YH15, 3YH5	<b>SONCAP</b>	
<b>GL</b>	3YH5	<b>MND</b>	

**CURRENT CONDITIONS:** AC (70V), DC (+)

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

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300<sup>0</sup>C for 1 hour (Optionally also available in vacuum-packed condition.)

### PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	50	75	110	225
Cartons / box	4	4	4	4
Pcs per box, Nos	200	300	440	900
Approx. Wt. of 1000 pcs,kg	98	66	45	22

## SPECIAL TESTS

TEST TYPE	REMARKS
HIC & SSCC (NACE)	Passed
CTOD at -10 <sup>0</sup> c	Passed



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