

SUPABASE

CLASSIFICATIONS

AWS A/SFA 5.1 E7018
IS 814 E B5426H,JX

IDENTIFICATION: Name Printed

CHARACTERISTICS

A basic-type, low-hydrogen, iron-powder electrode with metal recovery of 115% approx. It gives excellent arc stability, arc smoothness and easy slag removal. It has exceptional all-positional operating characteristics giving X-ray quality welds even for pipe welding in 5G & 6G 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 SA-414/SA-414M Gr. C&D (P. No. 1) • Gr.55, Gr. 60 steels of SA-516/516M (P. No. 1), IS2002, 2062

WELD METAL CHEMISTRY, (%)

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

MECHANICAL PROPERTIES- ALL-WELD

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

APPROVALS

ABS 3YH5, 3Y	BHEL E 7018
BV 3YHHH, 3YH5	IBR E 7018
DNV 3YH5	Toyo E 7018
IRS 3HHH, 3YHHH	NTPC E 7018
LRA 3,3YH15	BIS E B5426 H3JX

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°C for 1 hour (Optionally also available in vacuum-packed condition.)

PACKING DATA

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



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