

**SUPABASE**  
C-Mn STEEL (Low Hydrogen)

Special Welding Electrode for Pressure Vessels and Bridges

<b>CLASSIFICATION :</b>	EN ISO 2560-A	AWS A/SFA 5.1	<b>IS 814</b>	<b>APPROVALS :</b>
	E 42 2 B 32 H5	E 7018	E B5426H <sub>3</sub> JX	ABS/BV/DNV/IRS/LRA/ IBR/BIS/NTPC/BHEL

**KEY FEATURES :**

- Basic type iron powder electrode
- Metal recovery approx. 115%
- All position capability
- Radiographic weld deposit
- Suitable for pipe welding in 5G & 6G positions

**WELDING POSITION :** **AC (70 OCV)/ DCEP**

**TYPICAL APPLICATIONS :**

- Pressure vessels, Pipes
- Storage tanks
- Bridges, Heavy structures
- Joining steel of ASTM SA 414/414M Gr.C/D, SA 516/516M Gr.55/60, IS 2002, IS 2062

**REDRYING CONDITION :** 300°C for 1 hr (Also available in vacuum packed condition)

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :**

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	1.1	0.4	0.02	0.02
Specification	0.04-0.09	0.8-1.6	0.35-0.7	0.03 max.	0.03 max.

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact , J</b>	
					<b>-20°C</b>	<b>-30°C</b>
Typical	As Welded	540	470	26	66	48
Specification		500-600	440-550	24-30	50-80	30-70

Diffusible H<sub>2</sub> Content: <5 ml/100 gm

**PARAMETERS - PACKING DATA :**

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	225	4	22
3.15 x 450	100-130	110	4	45
4.0 x 450	140-180	75	4	66
5.0 x 450	180-240	50	4	98

**EQUIVALENT:** GMAW wire: **Automig-70S-6** FCAW wire: **Automig-FC-71T-1, Automig-FC-121**