



SUPABASE X PLUS

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 **E7018 H4R**

CLASSIFICATION:

ISO 2560-A
E 42 3 B 32 H5

IS 814
EB5426H₃JX

KEY FEATURES:

- Basic coated electrode
- Low hydrogen iron powder type
- Medium penetration
- High deposition rate
- Radiographic weld quality
- All position capability

APPROVALS: ABS/BV/DNV/IRS/LRA/NPCIL/BIS/CE

TYPICAL APPLICATIONS:

- Boilers, Pressure vessels
- Ship building, Storage tanks
- Heavy structures subject to dynamic loading
- Bridges, Pipe lines, Penstocks
- Joining IS 2002, 2062 steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.05	1.1	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:


	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact
					-30°C, J
Typical	As Welded	555	480	26	60
Specification		490 min	400 min	22 min	47 min

Hardness, 3 Layer: 200 BHN max

Diffusible H₂ Content: <5 ml/100 gm

Special Test: HIC & SSCC (NACE)

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC (70 OCV)/ DCEP	All Positions Except Vertical Down
2.5 x 350	60-90		
3.15 x 350	100-130		
3.15 x 450	100-130		
4.0 x 450	140-180		
5.0 x 450	180-240		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig I	Tigfil 70S-2	Automig FC 71T-5	Automelt B71	Automelt EM12K
Automig 70S-3	Tigfil 70S-3	-	Automelt B31	Automelt EH14
-	Tigfil 70S-6	-	-	-