

Special Welding Electrode for Pressure Vessels and Bridges

CLASSIFICATION :	EN ISO 2560-A	AWS A/SFA 5.1	IS 814	APPROVALS :
	E 42 2 B 32 H5	E 7018	E B5426H ₃ 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 % :

	C	Mn	Si	S	P
Typical	0.06	1.1	0.4	0.02	0.03
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 :

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

Diffusible H₂ Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
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