



SUPABASE X PLUS

C-Mn STEEL (Low Hydrogen)



Covered Electrode for 500 MPa High Tensile Strength Steel

CLASSIFICATION : ISO 2560-A

AWS A/SFA 5.1

IS 814

APPROVALS :

E 42 3 B 32 H5

E 7018

E B5426H₃JX

ABS/BV/DNV/IRS/GL/LRA
/IBR/BIS/NPCIL/MND

KEY FEATURES :

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

WELDING POSITION :



AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

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

REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.05	1.1	0.5	0.015	0.02
Specification	0.15 max	1.6 max	0.75 max	0.035 max	0.035 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at	
					-20°C	-30°C
Typical	As Welded	555	480	26	67	48
Specification		490 min	400 min	22 min	50-80	30-70

Hardness, 3 Layer: 160-200 BHN

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