

# SUPABASE / SUPABASE-X-PLUS

## World Class E 7018 Electrodes



- All position electrodes.
- A basic type, Low Hydrogen, Iron Powder electrodes.
- Gives excellent arc stability, arc smoothness and easy slag removal.
- Electrodes gives weldmetal of radiographics quality.
- Consistency in performance batch after batch, welder friendly.
- Moisture / Hydrogen controlled.
- Approved by Leading agencies.



### **ADOR WELDING LIMITED** Central Marketing Office

L. B. S. Marg, Bhandup (W), Mumbai - 400 078. INDIA Tel.: 22 2596 2564 / 77, 2596 0285 / 88  
Fax : 22 2596 6562 E-mail : cmo@adorians.com Website : www.adorwelding.com



# SUPABASE

## CLASSIFICATIONS

AWS A/SFA 5.1	E 7018
IS 814	EB 5426H <sub>3</sub> JX
EN 499	E 42 3 B 42 H 10
DIN 1913	E 5144B 1026
BS 639	E 5144B 12024(H)

Coating Type: Basic Deposition Eff., %: ~115

COATING FACTOR: Heavy IDENTIFICATION: Brand 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, wt%

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

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	RA	CVN Impacts, J		Hardness, BHN
	MPa	MPa	(L=4Xd)	%	-20°C	-29°C	
AW	500-600	440-550	24 min.	45 min.	50-80	30-70	200 max.

AW : As-welded

## APPROVALS

ABS	3YH5	NPCIL	E 7018
BV	3YHH	IBR	E 7018
DNV	3YH5	Toyo	E 7018
IRS	3H3YH		
LRS	3YMH15		
PDIL	E-7018		

## CURRENT CONDITIONS: AC, DC (+)

	6.3	5.0	4.0	3.2	2.5
230-	180-	140-	100-	60-	
310	240	180	130	90	

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

### PACKING DATA

	6.3	5.0	4.0	3.2	2.5
Dia., mm	450	450	450	450	350
Length, mm	5.25	5.25	5.25	5.25	5.25
Wt. per carton, kgs	4	4	4	4	4
Cartons/ box	21	21	21	21	21
Wt. per box, kgs					

# SUPABASE X PLUS

## CLASSIFICATIONS

AWS A/SFA 5.1	E 7018
IS 814	EB5426H <sub>3</sub> JX
EN 499	E 42 3 B 42 H 10
DIN 1913	E 5144B 1026
BS 639	E 5144B 12024(H)

COATING TYPE: Basic DEPOSITION EFF., %: ~115

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

## CHARACTERISTICS

A low-hydrogen, iron-powder electrode. It gives excellent arc stability, arc smoothness and very 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

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AW : As-welded

## APPROVALS

ABS	Gr. 3Y3H10	NPCIL	E 7018
BV	Gr. 3YHH	IBR	E 7018
DNV	Gr. 3YH5	Toyo	E 7018
IRS	Gr. 3H3YH	BIS	IS 814-91 EB5426H <sub>3</sub> JX
LRS	Gr. 3YMH15	RDSO	A4 & B2
GL	Gr. 3YH5	M & N DASTUR & CO.	

## CURRENT CONDITIONS: AC, DC (+)

	6.3	5.0	4.0	3.2	2.5
230-	180-	140-	100-	60-	
310	240	180	130	90	

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Wt. per box, kgs					

India's Welding Power House



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Area/Territory/Field Offices: Tel. Nos. : Ahmedabad (079) 6661 2788, 2657 9928 Andheri (022) 2826 0045/46 Bangalore (080) 2558 5125 Baroda (0265) 2362 285, 3259 954 Bhandup (022) 2596 2564/77  
 Bhubaneswar (0674) 2595 743, 2595 415 Chennai (044) 2822 1375, 2822 0816 Coimbatore (0422) 2303 869, 2304 281 Delhi (011) 4141 1049, 4141 1106 Faridabad (0129) 4033 908 Guwahati (0361) 2461 923, 2461 936  
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 Nagpur (0712) 3299 172 Navi-Mumbai (022) 2757 0099 / 8770 Pune (020) 2747 6906, 2747 6276-77 Rihand (05446) 274979 Raipur (0771) 2562 290, 4041 317 Silchar (03842) 245532 Siliguri 09832094887  
 Silvassa (0260) 3632 287, 3258 843 Sundernagar 09816049001 Trichy (0431) 4001 118, 4001 117 Vasco (0832) 2510 190 Vizag (0891) 6616 166