

Mild Steel & Low Hydrogen Electrodes

SUPER-LH (SPL)

CLASSIFICATION

E - 7018-1, IS : EB 5629 H3 JX

DESCRIPTION AND APPLICATIONS

Weld produces by SUPER LH (SPL) is of Radiographic quality which is exceptionally tough, ductile and fully resistant to hot and cold cracking and display a remarkable impact strength at room temperature as well as at sub zero temperature down to minus 50°C. Typical application includes welding of carbon steel, low alloy structural steel, steel sensitive to hydrogen embrittlement. Heavy and rigid structures, pressure vessels and

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10	1.60	0.75	0.03	0.03
Max	Max	Max	Max	Max
Cr	Ni	Mo	V	
0.20	0.30	0.30	0.08	
max	max	max	max	

TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at -30°C Joule
550.0	461.0	28.0	49.0

ELECTRODE SIZE AND 15 WELDING CURRENT : AC/DC (-)

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTO
2.00X300	60-80	200
2.50X350	80-100	150
3.15X450	100-135	105
4.00X450	160-190	70
5.00X450	220-270	45
6.30X450	270-320	30

APPROVALS:
BV, LRS, NPCIL, CIB (MP)
IOCL, BHEL, PDIL, EIL,
EACH BOX CONTAINS FOUR CARTONS.