



D & H INDIA LTD

Mild Steel & Low Hydrogen Electrodes



*High Efficiency - Optimum Productivity
X-ray Quality Sound Weld Metal*

Mild Steel & Low Hydrogen Electrodes

ECONOMY

CLASSIFICATION AWS:E-6013, IS :ER4221

DESCRIPTION AND APPLICATIONS

A general purpose, medium coated, all position, rutile type electrode suitable for general fabrication, structural and maintenance work in mild steel. The electrode is characterised by stable and smooth arc, low spatter, good deslagging and finely rippled weld bead. Weld deposit possesses good mechanical properties.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10	0.60	0.30	0.03	0.03
max	max	max	max	max

TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at 0°C Joule
478.5	434.0	28.0	63.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
2.50X350	60-90	260
3.15X350	100-140	150
3.15X450	100-140	150
4.00X450	140-180	95
5.00X450	180-220	65
6.30X450	270-320	35

APPROVALS:
BIS,IRS,RDSO

STANDARD

CLASSIFICATION AWS:E-6013, IS :ER4221X

DESCRIPTION AND APPLICATIONS

A medium coated, rutile type, all position electrode which can be described as TOUCH' electrode since it can be operated without maintaining an arc gap. Suitable for all types of mild steel structures, tanks and vessels, pipe lines, railway wagons, bridges, ship hull, boilers etc.The weld metal is sound, ductile and is of RADIOGRAPHIC quality..

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%)

C	Mn	Si	S	P
0.10	0.60	0.20	0.03	0.03
max	max	0.30	max	max

TYPICAL MECHANICAL PROPERTIES

UTS mpa	YS mpa	Elongation (%)	CVN Impact at 0°C Joule
480.5	435.5	28.0	65.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
2.00X300	40-60	250
2.50X350	60-90	225
3.15X350	100-140	130
3.15X450	100-140	130
4.00X450	140-190	85
5.00X450	180-220	55
6.30X450	270-320	30

APPROVALS:
ABS,DNV,LRS,BV,BIS,RDSO,
CIB(MP),NTPC,IOCL,EIL,BHEL,HPCL

SUPER-LH

CLASSIFICATION AWS : E -7018, IS : EB 5426 H2 JX

DESCRIPTION AND APPLICATIONS

SUPER-LH is a heavy coated low hydrogen iron Powder type electrode designed to weld heavy restrained joints subject to dynamic loading.Weld deposit is tough, ductile and is of RADIOGRAPHIC quality, deposition efficiency exceeds 115%. Typical applications include heavy structures subjected to dynamic loading and impact. Highly restrained joints, Boilers & pressure vessels, atomic reactor shells, bridges, railway wagons & coaches, earth moving equipment etc.

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
530.0	442.0	28.0	64.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
2.00X300	50-70	200
2.50X350	70-100	150
3.15X450	100-140	100
4.00X450	150-190	70
5.00X450	200-250	45
6.30X450	270-320	30

APPROVALS:
ABS,DNV,LRS,BV,BIS,RDSO,
CIB(MP),NTPC,IOCL,EIL,BHEL,HPCL,BPCL,JSPL



SUPER-LH (SPL)

CLASSIFICATION

AWS: 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 equipments subjected to severe stresses.

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 -45°C Joule
550.0	461.0	28.0	49.0

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
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:
ABS,BV,LRS,CIB(MP),IOCL,BPCL,BHEL,EIL

SUPER – LH – H4R

CLASSIFICATION

AWS: E 7018 H4R, IS: EB 5426 H3JX

DESCRIPTION AND APPLICATIONS

SUPER- LH- H4R is a basic coated, low Hydrogen, Iron Powder type of electrodes. The coating is humidity resistant. The deposited metal is tough, ductile and is of radiographic quality with deposition efficiency of 115% The electrodes is suitable for welding of heavy structures subjected to dynamic loading and impact, heavy restrained joints, boilers and pressure vessels and steels sensitive to hydrogen embrittlement etc.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%) (MAX)

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
490 min	400 min	22 min	60

Diffusible Hydrogen: Max 4ml/100gms of weld metal
Moisture contents in electrodes Covering (%by Wt) :
0.30% max

ELECTRODE SIZE AND WELDING CURRENT : AC/DC (+)

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
2.5x350	80 – 100	150
3.15x450	100 – 135	105
4x450	160 – 190	70
5x450	1220 – 270	45

APPROVALS:
BV

SUPER – LH – (SPL) H4R

CLASSIFICATION

AWS : E 7018 - 1 H4R,
EN ISO CODE:2560-AE424B32H5

DESCRIPTION AND APPLICATIONS

SUPER-LH-(SPL)H4R is a basic coated, low Hydrogen, Iron Powder type of electrodes. The coating is humidity resistant. The deposited metal is tough, ductile and is of radiographic quality with deposition efficiency of 115% The electrodes is suitable for welding of heavy structures subjected to dynamic loading and impact, heavy restrained joints, boilers and pressure vessels and steels sensitive to hydrogen embrittlement etc.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%) (MAX)

C	Mn	Si	S	P
0.10	1.60	0.25	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 (L=5d) %	CVN Impact at -45°C Joule
540 min	460 min	29 min	60

Diffusible Hydrogen: Max 4ml/100gms of weld metal
Moisture contents in electrodes Covering (%by Wt) :
0.30% ma

ELECTRODE SIZE AND WELDING CURRENT : AC/DC (+)

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTON
2.5x350	80 – 100	150
3.15x450	100 – 135	105
4x450	160 – 190	70
5x450	220 – 270	45

APPROVALS:
ABS,DNV,LRS,BV

D & H INDIA LTD

Igniting Welding Quality, Enabling Higher Productivity

D & H India Limited offers a wide range of Welding Consumables for diverse applications in industries like Steel, Shipbuilding, Petrochemical, Cement, Construction, Transport, Offshore, Energy, Repair & Maintenance, to name a few. Our products include Manual Metal Arc Electrodes, Submerged Arc Welding Fluxes & Wires, CO2 Welding Wires, Flux Cored Wires, Filler Wires and Metallurgical Cored Wires.

The company's initiative on Total Quality Management has resulted in ISO 9001-2015 certifications for both of its principal manufacturing facilities located at Indore and Ghatabilod.

Our modern manufacturing facility at Indore is equipped with the most sophisticated quality control and R & D infrastructure. We developed various special and ultra-special electrodes to meet the ever increasing and multifarious needs of our customers. Our qualified and trained field force renders expert technical service before, during and after the sales.

With a wealth of experience and technical know-how at our command, we even undertake to provide solutions for various welding related applications.

We are firmly committed to the welding technology, quality and customer satisfaction.



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