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D & H INDIA LTD

The Widest Range of Welding Products for Every Industry

www.dnhindia.com

Product Name	Classification AWS /SFA	Typical Chemical Composition of deposited weld metal %					Mechanical Properties of weld metal				Applications
		C	Mn	Si	S	P	UTS (Mpa)	YS (Mpa)	Elongation %	Impact at Joule	
Mild Steel Electrodes											
ECONOMY	E 6013	0.065	0.47	0.21	0.014	0.018	430	480	28	65 At 0°C	Medium coated all position electrode for general fabrication,-structural and maintenance work in mild steel,radiographic quality welds,
STANDARD	E 6013	0.062	0.49	0.22	0.014	0.017	440	485	28	65 at 0° C	Medium heavy coated all position electrode mild steel structure,tanks & vessels,pipe line,railway agon,bridges,boil-ers etc,radiographic quality welds,
Low Hydrogen Electrodes											
SUPER-LH	E 7018	0.068	1.14	0.44	0.012	0.015	440	540	28	60 At 30°C	Heavy coated low hydrogen electrode for heavy restrained joints subject to dynamic loading,heavy structure,boilers & pressure vessels,radiographic quality welds with 115% deposition efficiency,
SUPER-LH-(SPL)	E 7018-1	0.062	1.4	0.24	0.011	0.014	460	560	28	50 at -45°C	Heavy coated low hydrogen electrode,tough,ductile,resistant to hot & cold cracking,radiographic quality welds with remarkable impact strength at -45°C,
SUPER-LH-H4R	E 7018 H4R	0.10 Max	1.60 Max	0.75 Max	0.03 Max	0.03 Max	400 Min	490 Min	22 Min	27 joule Min at -30°C	Basic Heavy coated moister resistant electrode with extra low hydrogen less than 4 ml/100 gm with additional chemical element like Cr-0.20%,Ni-0.30%,Mo-0.30%,V-0.08 Max,
SUPER-LH(SPL) - H4R	E 7018-1 H4R	0.10 Max	1.60 Max	0.75 Max	0.03 Max	0.03 Max	400 Min	490 Min	22 Min	27 joule Min at -45°C	Basic Heavy coated moister resistant electrode with extra low hydrogen less than 4 ml/100 gm with additional chemical element like Cr-0.20%,Ni-0.30%,Mo-0.30%,V-0.08 Max,

NOTE: *This leaflet covers only common and frequently asked welding products in every Industry.*

Since, our manufacturing range is vast, Therefore, Your enquiry for other products not covered in this leaflet is also solicited.

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Stainless Steel Electrodes											
CROMALLOY-B	E 308-L	0.08 Max	0.5-2.5	1.0 Max	18.0-21.0	9.0-11.0	0.75 Max	0.75 Max	550 Min	30 Min	Low carbon SS electrode with controlled ferrite,highly resistant to cracking corrosion and oxidation at high temperature,suitable for welding of AISI 301,302,304,308 and equivalent steels,
CROMALLOY-309L	E 309-L	0.15 Max	0.5-2.5	1.0 Max	22.0-25.0	12.0-14.0	0.75 Max	0.75 Max	550 Min	30 Min	Rutile coated electrode excellent resistant to corrosion and oxidation upto 11000C,suitable for welding of similar stainless steel as well as in dissimilar metal joining between MS and low alloy and stainless steel,
CROMALLOY-2C	E 316-L	0.08 Max	0.5-2.5	1.0 Max	17.0-20.0	11.0-14.0	2.0-3.0	0.75 Max	520 Min	30 Min	Rutile coated electrode highly corrosion resistant weld deposit with high creep strength,recommended for welding of AISI 316 steel and equivalent steels,
Mild Steel Electrodes General Purpose											
GEM	E 6013	0.08	0.46	0.22	-	-	-	-	480	27	Medium coated rutile type all position AC/Dc electrode for general fabrication,mild steel structures,storage tanks,rail coaches etc
Stainless Steel Electrodes General Purpose											
SUPERCROM-1AL	E 308-L	0.05	0.80	0.22	18.5	8.5	-	-	555	37	Stainless steel electrodes suitable for welding of AISI 301,302,304,308 and equivalent grades of SS,
SUPERCROM-309L	E 309 -L	0.03	0.75	0.22	23.0	12.5	-	-	550	33	Corrosion and scaling resistant weld metal,suitable for welding or overlay on stainless steel to itself or dissimilar steel like Stainless steel to carbon steel /variety of steels.
SUPERCROM-316L	E 316-L	0.03	0.8	0.22	18.0	12.0	2.3	-	535	35	A product depositing stainless steel weldmetal containing 18% Cr,11% Ni,2% Mo.Recommended for welding or overlay on AISI 316 and equivalent stainless steel grades. It has good creep strength and resist scaling even at elevated temp upto 900OC

Submerged Arc Welding Fluxes & Wires					
Our brand	Flux Type	Aws Clasification	Suggested Welding Wire	Suggested Base Metal	Typical Application
SUPERMELT-II	"Agglomerated Aluminate rutile type acidic"	SAF 5.17 F7AZ-EL8 F7A2-EM12K	"EL-8 SUPERMELT GR-A EM-12K SUPERMELT -12K"	Steel Gr like 2062, ASTM A285 Gr C, ASTM516 Gr60, BS 1501-151 Gr 400 etc	The combination is suitable for general fabrication where low or medium tensile strength is required.
SUPERMELT-II (SPL)	Basic type Flux	SFA-5.17 F6A2-EL8 F7A4-EM12K F7A4-EH14	" EL-8 SUPERMELT GR-A EM-12K SUPERMELT -12K EH-14 SUPERMELT GR-B"	Steel Gr LikeASTM A29 Gr 1015/Gr 1020, astm a 285 Gr ABCD, ASTM A516 Gr60/70 & A36	The combination has very good Mechanical property including impact At minus 40*c. Recommended for heavy fabrication Work where midium and high tensile Strength is required.

Frequently Asked Welding Products for Every Industry

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Co2 Mig Welding Wire															
MIGARC WS-6	ER-70S-6	0.06-0.15	1.40-1.85	0.80-1.15	0.035 Max	0.025 Max	0.15 Max	0.15 Max	0.15 Max	0.50 Max	430	480	28	65 At 0°C	A highly deoxodised copper coated Manganese-silicon bearing wire for continous welding with CO2 shield gas and other commercialy availiable shielding gas,radiographic quality welds,suitable for welding of mild steel,low alloy steel,general fabrication etc,
Flux Cored Welding Wires															
SUPERCORE 71T-1	AWS 71T-1C	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	-	-	-	-	490-670	390 Min	22 Min	27 Min At -20°C	A superior quality flux cored wire suitable for welding in all position on wide range of welding current under CO2 shielding,gives radiographic quality welds,suitable for joining steel confirming to ASTM SA-36/SA-36M and SA-283/SA 283M (A,B,C,D Grades) and SA-414/SA 414M
SUPERCORE 71T-5	AWS 71T-5C	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	-	0.5 Max	-	-	490-670	390 Min	22 Min	27 Min At -40°C	A superior quality flux cored wire suitable for welding in all position on wide range of welding current under CO2 shielding,gives radiographic quality welds,suitable for joining steel confirming to ASTM SA-36/SA-36M and SA-283/SA 283M (A,B,C,D Grades) and SA-414/SA 414M
SUPERCORE 81T1-B2	AWS 81T1-B2C	0.05 -0.12	1.25 Max	0.80 Max	0.03 Max	0.03 Max	1.0-1.50	-	0.40-0.65	-	550-690	470 Min	19 Min	-	A low alloy steel flux cored wire with an external shielding gas, this wire is intended for single and multiple pass welding in all positions,is recommended for welding for high pressure steam pipes of boilers, oil refining processing equipment, pressure vessels and castings of the same alloy content,
SUPERCORE 91T1-B3	AWS 91T1-B3C	0.10 Max	1.60 Max	0.75 Max	0.03 Max	0.03 Max	2.0-2.50	-	0.90-1.20	-	620-760	540 Min	17 Min	-	A low alloy steel flux cored wire with an external shielding gas, this wire is intended for single and multiple pass welding in all positions, this wire designed for welding of 2.25% chromium, 1% molybdenum low alloy steels,recommended for welding of similar composition creep resistant steel,

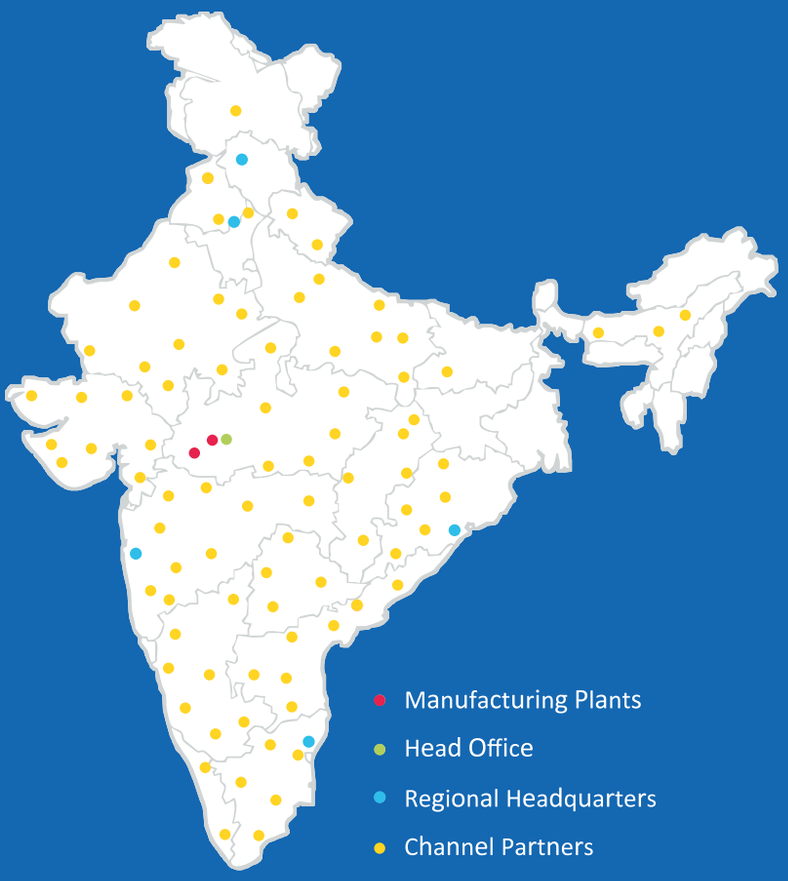
We being one of the leading welding consumable manufacturer, manufacture and supply complete range of Welding Electrodes, Different Grade of MIG Wires, Flux Cored Wires, SAW Wires and Fluxes and Filler Wires.

Our performance proven complete range of Repair & Maintenance electrodes known as **“LOW HEAT INPUT ELECTRODES”** are also available.

Expanding Horizons to Global Markets

Network For Efficient Support

D & H India Ltd. has developed its nationwide presence to support every customer promptly. Our qualified and experienced field force is located strategically to render technical support to our customers as and when required at site. Our in-depth dealer network penetrates all important and major industrial belts to serve every customer with continuously updated stocks. We also have regional headquarters at Mumbai, Delhi, Chennai and Kolkata with Head Office at Indore. Our state-of-the-art manufacturing plants are also located at Indore (M.P),Dhār (M.P) and Durg (C.G) INDIA



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