

Mild Steel & Low Hydrogen Electrodes

SUPER-LH

CLASSIFICATION

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
555.0	475.0	28.0	78.5

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

SIZE DxL(MM)	CURRENT Amps.	PIECES /CARTO
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:

BIS (ISI), RDSO, CIB, (MP), NPCIL, LRS, ABS, BV, DNV, IRS, MMD, NTPC, IOCL, BHEL, EIL, PDIL, M.N. Dastur & Co.
EACH BOX CONTAINS FOUR CARTONS.