



SUPRATHERME(SPL)MOD-H4R

CODIFICATION: AWS : SFA 5.1 E7018-1H4R
IS : 814 EB5626H₃JX

CHARACTERISTICS AND APPLICATIONS:

Moisture resistant hydrogen controlled basic coated electrode for producing tough and ductile weld of radiographic quality in Boilers, Pressure vessels, Medium carbon steels, Cast steel and problematic steels. The weld metal is clean and has low level of impurities, thus having unique properties. The electrode can be used in all conventional positions of welding. It is ideally suited for welding carbon steels used in the construction of equipment subjected to heavy dynamic load, impact and severe service conditions in sour gas service.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.06	1.40	0.30	0.010	0.015

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength at
(MPa)	(MPa)	(L = 4d)%	minus 45°C (Joules)
540	430	29.0	80

CORROSION TESTS: The weld metal meets the requirements as per NACE: TM-01-77-96 (SSCC) and TM-02-84-96 (HIC)

DIFFUSIBLE HYDROGEN CONTENT: 4 ml / 100 gms of weld metal Max

MOISTURE AS CONDITIONED: 0.30 Max

MOISTURE AS EXPOSED (80% RH, 27°C FOR 9 HRS): 0.40 Max

ADVANTAGE: Electrodes are Vacuum packed, no need of drying and can be used straight on the job.

CURRENT AND PACKING DATA: AC/DC (+)

Size (mm)	: 5 x 450	4 x 450	3.15 x 450	2.5 x 350
Dia x Length				
Current Range	: 190-250	140-200	90-140	70-100
(Amps)				
Qty. (pcs./Carton)	: 20	30	45	80

PRECAUTIONS:

1. Restrict the heat input, use short arc and stringer bead.
2. Re-dry the electrodes at 250°C for 1 hour, if expose to atmosphere.