



## SUPRATHERME(SPL) MOD

**CODIFICATION :**  
AWS : SFA 5.1 E7018-1  
IS : 814 EB5626H<sub>3</sub>JX  
EN ISO : 2560-A E 42 4 B 3 2 H5

### CHARACTERISTICS AND APPLICATIONS :

Supratherme (Spl) Mod is a basic coated iron powder type, high yield, and hydrogen-controlled electrode. Easy to operate in all conventional welding positions. Radiographic quality welds having excellent cracking resistance. 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	0.40	0.010	0.013

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact (Joules) at minus 45°C	CVN Impact (Joules) at minus 40°C	Weld Metal Hardness (BHN)
550	450	29	80	100	180

**CORROSION TESTS:** Passes corrosion test as per NACE standard TM-01-77- 96 (SSCC) and TM-02-84-96 (HIC)

**DIFFUSIBLE HYDROGEN CONTENT :** 5ml/100 gms of weld metal Max.

### CURRENT AND PACKING DATA: AC/DC(+)

Size (mm)	:	5x450	4x450	3.15x450	2.5x350
Dia x Length					
Current Range (Amps)	:	200-250	150-190	100-140	70-100
Qty. (Pcs./Carton)	:	30	50	75	100

**APPROVAL: CE**

### PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300°C for 2 hours.
2. Use short arc, minimize heat input.