

SUPRATHERME-Ni (SPL)

CODIFICATION :

AWS : SFA 5.5 E8018-G
EN ISO : 2560-A E 46 5 1Ni B 4 2 H5

CHARACTERISTICS AND APPLICATIONS :

Supratherme-Ni(Spl) is a basic coated, low hydrogen, iron powder type electrode yielding a weld metal containing 1.5% Mn and 0.7% Ni. Excellent quality welds for welding heavy sections of fine grained high strength steels with particular reference to low temperature service down to minus 60°C. Typical applications include welding of fine grained Q&T steels for pressure vessels, tanks, penstocks, where high strength and sub-zero temperature toughness properties are of importance.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	S	P	Ni
Percent :	0.07	1.25	0.30	0.018	0.018	0.75

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at minus 50°C (Joules)
565	515	27.0	60

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

CURRENT AND PACKING DATA: DC(+)

Size (mm)	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length					
Current Range (Amps)	270-330	220-280	160-190	110-135	80-100
Qty.(Pcs./Carton)	25	35	55	75	125

APPROVALS: CE, EIL, PDIL

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300°C for 2 hours.
2. Minimise heat input during welding.

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