



X BOND

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 E7018

CLASSIFICATION:

ISO 2560-A
E 42 2 B 32

IS 814
EB5426H₃JX

KEY FEATURES:

- Basic coated electrode
- Low hydrogen iron powder type
- Tough and ductile weld
- Radiographic weld deposit
- Deposition efficiency is typically 110%
- All position capability
- Pipe welding in 5G and 6G positions

APPROVALS: ABS/IRS/LRA/IBR/CE

TYPICAL APPLICATIONS:

- Structural welding
- Storage tanks
- Boilers, Pressure vessels
- Bridges, Pipes
- Joining steel ASTM SA 414/414M Gr.C/D/E, SA 516/516M Gr.55/60

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


C	Mn	Si
0.1	1.0	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

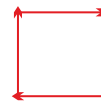
	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact - 30°C, J
Typical	As Welded	525	440	26	55
Specification		490 min	400 min	22 min	27 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV)/ DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	100-130	
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4.0 x 450	140-180	
5.0 x 450	180-240	

All Positions Except Vertical Down



Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing