



SUNTHERM – HT SPL

CLASSIFICATION:

AWS: A 5.5 : E 11018M
IS 1395 E76 BM 326Fe

DESCRIPTION:

SUNTHERM – HT is basic coated extra low hydrogen controlled, low alloy high tensile steel electrode suitable for welding fully killed fine grained steel giving a tough weld met without the risk of temper brittleness. The all position electrode has an excellent arc and current carrying characteristics, with an easily removable slag and excellent bead finish contributing to its immense welder appeal.

TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.05	Mn	1.60	YS	70-77 Kg/mm ²
Si	0.45	Ni	2.0	UTS	78-85 Kg/mm ²
Mo	0.40	Cr	0.25	EL (L=5d)	20-26%
				Impact (CVN) at -50°C	28-58 Joules

TYPICAL APPLICATIONS:

It is widely used for welding of low alloy high strength structural steels including quenched and tempered steels such as USS T1, heat treated fine grained steels like N-A-XTRA 70, T1, HY80 and A517 grades generally used for penstock, earth moving equipment and other heavy steel fabrication.

CURRENT RANGE & PACKING DATA:

Size	Length	Current Range	Qty of Electrodes in a	Qty of Electrodes in a
(mm)	(mm)	(Amps)	Carton	Cardboard box
3.15	450	90-125	5 Kg	20 Kg
4	450	120-180	5 Kg	20 Kg
5	450	160-240	5 Kg	20 Kg

PACKING:

Electrodes are packed in Cartons and four of these Cartons are shrink wrapped in a cardboard box.