

# Supra®

## Key Features

- All position rutile electrode with excellent vertical down welding properties
- Weldable in all positions with one current setting
- Premium electrode Made in Europe

## Typical Applications

- Shipbuilding repairs
- Excellent on painted or rust covered steel
- Recommended for bridging wide gaps

## Conformances

<b>AWS A5.1:</b>	E 6012
<b>AS/NZS 4855-A:</b>	E 38 0 RC 11
<b>AS/NZS 4855-B:</b>	E 4312 A
<b>ABS, BV, DNV-GL, LR, RMRS:</b>	2

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	588694-1	CBOH 2.1 kg (6 x CBOH per carton)
3.2	350	588695-1	CB 4.8 kg (3 x CB per carton)

## Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ 0°C
<b>Requirements - AWS</b>	330 min	430 min	17 min	Not specified
<b>Requirements - AS/NZS</b>	380 min	470-600	20 min	Min 47
<b>Typical Results - As Welded</b>	470	550	23	56

## Deposit Composition

	%C	%Mn	%Si
<b>Typical Results - As Welded</b>	0.12	0.5	0.6

## Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
AC / DC-	70-90	95-130

## Welding Parameters, Optimum Fill Passes

Diameter mm	Welding Positions					
	PA/1G	PB/2F	PC/2G	PF/3G up	PG/3G down	PE/4G
2.5	85A	85A	80A	80A	80A	80A
3.2	115A	115A	120A	120A	120A	120A