

STANDARDISATION OF WELDING ELECTRODES IN HPGCL

Sr. No.	Application	AWS Code	Standardised welding Electrodes		size	Unit
			Brand Name of Electrodes	Name of Manufacturer		
A) General purpose electrodes						
1	General purpose electrodes for mild & medium steels FOR ALL POSITION WELDING NOT FOR RADIOGRAPHY QUALITY JOB	E-6013	a) Overcord	Superon	2.5 mm,3.15/3.2 mm,4 mm	Nos
			b) Norma	D&H Secheron		
			c) Ferrospeed Plus	ESAB		
			d) Superbond	Ador Welding		
			e) Regular S	Honawar electrodes pvt ltd		
			f) Speedarc	voltarc Electrodes Pvt Ltd		
			g) Electra 9	Fusion Engg Products		
			h) Steelon Std	Modi Arc		
			i) Gricon black	GEE Ltd		
2	Special category MS Electrode for high strength welding of carbon steel of RADIOGRAPHY QUALITY(LOW HYDROGEN ELECTRODE FOR THICK SECTIONS AND STRUCTRAL STEELS)	E7018(radiography quality)	a) supercito	Superon	2.5 mm,3.15/3.2 mm,4 mm	Nos
			b)supertherme	D&H Secheron		
			c) ESAB 36 H	ESAB		
			d) Superbase	Ador Welding		
			e) ultimate 18	Honawar electrodes pvt ltd		

f) superarc	voltarc Electrodes Pvt Lt
g) basicote 6	Fusion Engg Products
h)Modi 7018	Modi Arc
i) Gricon green	GEE Ltd
j)WA7018	weld alloy products Noida
k) ultra 7018	maruti weld ltd gurgaon

B) Pressure parts applications electrodes

3	Special purpose / radiography quality (IBR approved) electrodes for mild & medium steel pressure parts.	E-6013 IBR quality	a) Overcord S	Superon	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
			b) Superbond S	Ador Welding		
			c) Medio	D&H Secheron		
			d) vordian	ESAB		
			e) Maruti 44	maruti weld ltd gurgaon		
4	Electrodes for low alloy high tensile low hydrogen for pressure parts pipings	E-7018-1	a) Supertherme Spl	D&H	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
			b) Tenalloy Z-plus	ADOR Welding		
			c) ESAB 36 H-SPL	ESAB		
5	Low Alloy Steel SA213T11 (IBR approved) for welding pressure parts of 1.25 Cr 0.5Mo(T 11) tubes and	E-8018 B2	a) Chromotherm 1	D&H	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
			b) Chromocord	ADOR Welding		

	Cr,0.5MO(T 11) tubes and pipes of boiler and turbine		c) Chromoten	Ador Fontech	*****	
6	Low Alloy Steel SA213T22 (IBR approved) for welding pressure parts of 2.25 Cr,1MO(T 22) tubes and pipes of boiler and turbine	E-9018 B3	a) Chromotherm 2	D&H	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
			b) Chromocord S	ADOR Welding		
			c) Chromoten C	Ador Fontech		
7	Low alloy steel SA 213 T91	9015B-9	a) Chromotherm-9 (SPL)	D&H	2.5 mm,4 mm	nos
			b) Chromoten-9M	Ador Welding		

C) SS Welding electrodes

8	S.S 304 /308 High Pressure Parts	E-308-16	a) Super Inox-1A	AODR Welding	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
			b) Rutox "A"	D&H Secheron		
			c) Xuperfab 308-16	L&T		
			d) OK-61.50	ESAB		
9	S.S 347 High Pressure Parts,	E-347-16	a) Xuper Inox-1B b) Rutox "A" (Stabilished) c) XuperfabE-347-16 d) OK-61.80	a) ADOR Welding b) D&H Secheron c) L&T d) ESAB	2.5 mm,3.15/ 3.2 mm,4 mm	Nos
10	SS welding electrode for nozzle tip repair, buffer plate to body jointing, very high temp. SS joining in Superheater area.		Eutectic Stantrode - D	L&T	2.5 mm,3.15/ 3.2 mm,4 mm	Nos

D) Hard Facing Electrodes

11	Tubular welding electrode for hard facing of burner coal nozzle body, coal pipes, coal bends &,BAH gate repair,		a) Cobalarc-1-M	ESAB	6.3 mm	Kg			
			b) TA-I	Ador Fontech					
			c) Ferrogold 609-T	Superon					
			d) CPET-071	L&T					
			e) Lo Therme T901	D&H Secheron					
12	Hard facing electrode for final layer application in other non critical applications like crusher rotor.		TERRA HARD-85 LH-715 Selectrode -84.78 Therme- 604	OK Lo-	L&T ADOR Fontech D&H	ESAB	5 mm,3.15/ 3.2 mm,4 mm	Kg	
13	Hard facing electrode for heavy temp applications like coal nozzle tips.		a) XHD-6715 N		L&T		4 mm	Kg	
14	Critical application of hard facing like MDV,MPO,Ventury, coal bends,fuel inlet elbows and other hard facing areas		Euctrode N 700		L&T		4 mm	Kg	
E) Cast Iron Electrodes									
15	Special purpose Cast iron electrode (high NI based) machinable		a) Lotherme-705		D&H Secheron	3.15/3.2 mm,4 mm	Kg		
			b) LH-115		Ador Fontech				
			c) Xuper Xyron 242		L&T				

16	Nodular cast iron welding crack resistant for welding of casting, Machinery parts , plumber block, motor housing, motor end cover (non machinable)		a) OK Selectrode 92.58	ESAB	2.5/3.2/4	Kg
			b) LH-119	Ador Fontech		
			c) Diffusion greyloy 850	diffusion		
			d) Terra CI 094	L&T		
			e) Lo Therme 703	D&H Secheron		
17	Cast iron electordes for crack resistance like ash sluury pump housing and various spares of AHP		Xuper 2240	L&T	3.15/3.2 mm, 4 mm	Kg
18	Cast iron electordes for oil soaked cast iron welding like mill gear box cover and other CI housings.		a) Xuper 2233 N b) LH-113N	L&T	3.15/3.2 mm, 4 mm	Kg

F) Cutting Electrodes

19	Cutting electrodes		a) LH-901	Ador Fontech	3.15/3.2/4 mm	Kg
			b) Cutrode	L&T		
			c) Lotherm 801	D&H Secheron		
			d) Terrocut	ESAB		

G) Dissimilar Metal Electrodes

20	Alloy steel electordes for dissimilar metal jointing of unknown composition for high strength joint, reclamation of lower journal housing, bearing area of roller journal shaft, motor shaft repairing, pump shaft, repairing of turbine shaft, clinker grinder shaft, dozer parts, sump pump and gear box repairing		680 CGS (For critical all position application)	L&T	4 mm	Kg
21	Alloy steel electrode for shaft journal repair/build up with low coefficient of friction, corrosion resistant, machinable, mirror smooth finish		a) CPSM 022 b) LH-128 S	L&T ADOR	2.5 mm	Kg

H) Other Metal Electrodes

22	Welding NI alloy & Monel for turbine repair, HP / IP parting planes, diaphragm liners		a) Nicro 82	Thyssen	3.15/3.2 mm	Kg
			b) D&H 1212	D&H Secheron		
			c) SPAC0400	Ador		
			d) ESAB CNI F	ESAB		
			e) CPGW 034	L&T		
23	Runner Repair of Hydel machines		LH-128B	ADOR Fontech	4 mm	Kg