

From an ISO 9001 : 2008 and 14001 : 2004 Certified Company



Accura Weldrods Kovai Pvt Ltd

Our Products - Hot Products

Mild Steel Electrodes

Brand Name	AWS Code	Application	Mechanical Properties		
			UTS - N/mm ²	Elongation in %	CVN Impact in J
SUN BOND E6013	A 5.1 E6013	It is used for general purpose welding like ship hulls, tanks, vessels, bridges, railway wagons, steel frames, truck frames and bodies, Ornamental iron, Machinery guards, fertilizer plants and boilers or wherever appearance is important or desirable.	460 - 540	22 - 26	50 - 80 J at 0°C
SUN BOND E6013 SS	A 5.1 E6013		460 - 540	22 - 26	50 - 80 J at 0°C
SUN BOND E7016	A 5.1 E7016	This type of electrode are widely used for welding of mild steel, low-alloy steels, for joining of cast steel to mild steel and for depositing buffer layer before hard facing, welding in heavy machinery such as roller, tractors, earth moving equipment's, ship, rail way coaches etc.	500 - 580	24 - 30	60-150 J at -30°C
SUN BOND E7018	A 5.1 E7018	This type of electrode are widely used for heavy restrained joints subject to dynamic loading, boilers, pressure vessels, bridges, earth moving equipment, blast furnace shells, pipelines and heavy structures, ship plates boilers etc.	510 - 580	25 - 30	80-150 J at -30°C
SUN BOND E7018-1	A 5.1 E7018-1	This type of electrode are widely used for heavy restrained joints subject to dynamic loading, welding of C-Mn steels boilers, pressure vessels, bridges, spheres, storage tanks and piping used for sour gas service, earth moving equipment, blast furnace shells, pipelines and heavy structures, ship plates boilers etc.	510 - 600	25 - 30	50-150 J at -46°C
SUN BOND E7018-1H4R	A 5.1 E7018-1H4R	This type of electrode are widely used for heavy restrained joints subject to dynamic loading, welding of C-Mn steels boilers, pressure vessels, bridges, spheres, storage tanks and piping used for sour gas service, earth moving equipment, blast furnace shells, pipelines and heavy structures, ship plates boilers etc. Available in Vacuum Pack.	510 - 640	25 - 30	50-150 J at -46°C

Stainless Steel Electrodes (Available in Vacuum Pack)

Brand Name	AWS Code	Application	Mechanical Properties	
			UTS - N/mm ²	Elongation in %
SUN BOND E308L	A 5.4 E308L-16	For welding of AISI 301, 302, 304L & 308L steels household's articles, hospital apparatus, kitchen equipment soap, diary, brewery industry etc. Dump impellers, for building-up stainless surfaces on centrifugal pump impellers and shafts, valve faces, seats and chemical plants, pharmaceutical equipment, architectural fabrication etc.	510 - 600	35 min
SUN BOND E309L	A 5.4 E309L-16	The electrode are suitable for welding of AISI type 309, 309L steel, joining of straight chrome steels to low alloy steel or carbon steel deposition of buffer layer on mild steel. Building up mild steel to improve wear resistance and for building up worm parts of wear resisting steels, etc.	520 - 650	30 min
SUN BOND E316L	A 5.4 E316L-16	The electrode are suitable for welding of AISI type 316, 316L, 317 Paper pulp industries, Chemical Industries, Fertilizer plants, Paint, Dye industries etc.	520 - 600	30 min

Hard Facing Electrodes

Brand Name	AWS Code	Application	Properties of all Weld Metal				
			Hardness	Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
SUN BOND HF 350	-	For welding of roller, shafts, cranes, brake shoes, gears shaft, reclamation of conveyor parts, latch bars and plates, axles, wobblers ends, shear blades, couplings, steel castings etc.	As Welded 330 - 350 BHN	Good with carbide tools	Excellent	Good	N.A
SUN BOND HF 550	-	For welding of crusher hammers, conveyors, bucket lips, excavator teeth, disintegrator hammers, crane wheels, mine rails, metal cutting and forming tools, cane cutting knives, rock crushing jaw, bamboo chipper knives and used for surfacing tractor rollers, idlers in steel mill, Campus, Shear blades, Sprockets, Break Shoes, Forging Dies, Cement Die Rings, Crushing Hammers etc.	As Welded 540 - 580 BHN	Non - Machinable	Excellent	Good	N.A
SUN BOND HF 600	-	A rutile coated electrode depositing air hardening type of weld metal having the hardness in the range of 600-650 BHN approx. The weld metal is non- Machinable. It can withstand heavy abrasion, friction, and moderate impact excellent arc stability low spatter loss. All sizes strike and re-strike easily. Slags are easily detachable. Weld beads are smooth, uniform and excellent appearance.	As Welded 600 - 650 BHN	Non - Machinable	Excellent	Good	N.A
SUN BOND HF 550 LH	-	Suitable to work on high carbon and high sulphur steels without cracks. Drill bits, Impellers, oil expeller worms, sprockets and Unique in its versatility of applications in area of building up worn out parts and hard facing. For the hard surfacing of mild steel, carbon steels, low alloy steels as an extremely wear and abrasion resisting layer of average to serious toughness.	As Welded 540 - 580 BHN	Non - Machinable/ Only grinding	Excellent	Good	N.A
SUN BOND HF MANGAN	-	For welding manganese steel component, dredgers bucket teeth manganese steel railway crossing points, cement grinding rings, austenitic manganese steel casting, rock crushing jaw. Suitable for stone crushing jaws, excavator teeth's, Mn steel rails, hammers, crusher mantle, Cement grinder rings, Rail crossovers, Rail frogs and switches etc.	As welded 200 BHN(approx) Work Hardness to 500 BHN(approx)	Good	Average	Excellent	Average

Our Products - Hot Products

Pipe Welding Electrodes

Brand Name	AWS Code	Application	Mechanical Properties		
			UTS - N/mm ²	Elongation in %	CVN Impact in J
SUN BOND E6010	A 5.1 E6010	It has wide applications and the most important is its use in joining pipe lines, where the electrode is operated in all welding positions. The weld deposit is also of high quality and meets radiographic requirements on multipass runs. Other applications include welding mild steel, galvanized steel, low alloy steel, structural work such as building s and bridges, pressure vessel fittings, storage tanks etc.	460 - 540	22 - 26	50 - 80 -30°C

Cutting Electrodes

Brand Name	AWS Code	Application	Mechanical Properties	
			UTS - N/mm ²	Elongation in %
SUN BOND CUTROD	-	Cutting of mild steels, low carbon steels, manganese steels, cast iron, copper, manganese, aluminium, nickel and their alloys, casting risers and gates and dressing for filling up etc. Absolutely suitable for burning rivets, dismantling work at site and for cutting out unwanted metal in castings.	-	-

Cast Iron Non Machinable Electrodes

Brand Name	AWS Code	Application	Mechanical Properties	
			Condition	Hardness
SUN BOND CINM	A 5.15 Est	This electrode can be used for welding of cast iron frame, machine casting, pump housing, gear box, joining of cast iron to mild steel etc. Welding of cast iron parts for all types of general reclamation or repair work, where each inability is not a primary consideration.	-	-

Cast Iron Machinable Electrodes

Brand Name	AWS Code	Application	Mechanical Properties	
			Condition	Hardness
SUN BOND CIFN	A 5.15 ENi Fe-CI	This electrode can be used for welding and repairing of cast iron component, reclamation of gears and pulley, water pump housing cast iron to steel, cast iron die, pumps, repairs broken castings etc.	As Welded	135 - 180 BHN
SUN BOND CINI	A 5.15 ENi CI	This electrode can be used for welding and repairing of cast iron component, cast iron to steel, cast iron die, pumps, repairs broken castings, filling up of small cavities etc.	As Welded	135 - 180 BHN
SUN BOND MONEL	A 5.15 ENi-Cu-B	This ideal for defects in foundry cast iron castings, repairing of cracks, broken parts of cast iron, well suited for Gears, Machinery parts, Pump bodies etc.	As Welded	140 - 180 BHN

Our Unique Selling Product (USP)

Constant Supply

Consistent Quality

Easy Detachable Slag

Excellent Weld Strength

Economical Low Smoke

Low Spatter Eco Friendly

Economical Electrodes Excellent Finish

Manufacturing Facility



Our Infrastructure

AWR's state-of-the-art manufacturing plant in Tamil Nadu, is equipped with fully functioning automated machines, backed with top notch R & D infrastructure and quality control. The manufacturing plant has adequate resources that includes dynamic managerial team, skilled technicians and good number of semi skilled workers to achieve the production targets.

Quality Control



Our Testing Facility

AWR's finely built laboratory houses chemical, mechanical and welding labs which are equipped with Universal testing machine like Charpy & Izod impact tester, Rockwell hardness tester. AWR follows a Standard procedure to check and tests which are performed on raw materials for their suitability before sending to production department. Special work-stations are installed to test the quality of manufactured items, and each lot using unique batch number system for easy identification and traceability of the finished goods.

Quality

As "Quality Signifies Process" we adhere to the strict quality norms right from the receipt of raw material till the final dispatch. As customer satisfaction is the crucial differentiating factor, we are determined to retain our competitive edge through new advanced technology.



Manufactured by:

ACCURA WELDRODS Kovai Pvt Ltd

No.1/15-2, PONNANDAMPALAYAM, S.F.No.454 PART 475/2,KANIYUR VILLAGE, COIMBATORE-641 659.

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Phone: +91 97888 55677 | Customer Care: +91 94421 62983

MADE IN INDIA

PRODUCT PACKING DETAILS



Mild Steel Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Pieces Per Packet	Packets Per Box	
	SUN BOND E6013	1.60 x 250 2.00 x 300 2.50 x 350 3.15 x 350/450 4.00 x 450 5.00 x 450	16 14 12 10 8 6	350 200 135 90 60 40	5 8 8 8 8 8	
	SUN BOND E6013 SS	2.50 x 350 3.15 x 350 4.00 x 450 5.00 x 450	12 10 8 6	100 60 40 30	8 8 8 8	
Mild Steel Low Hydrogen Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND E7016	2.50 x 350	12	5 Kgs	4	20 Kgs
	SUN BOND E7018	3.15 x 350/450	10			
	SUN BOND E7018-1	3.20 x 450	10			
	SUN BOND E7018-1H4R (Available in 2 Kgs Vacuum Pack)	4.00 x 450 5.00 x 450	8 6	2 Kgs	10	
Hard Facing Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND HF 350	2.50 x 350	12	5 Kgs	4	20 Kgs
	SUN BOND HF 550	3.15 x 350				
	SUN BOND HF 600	3.15 x 450	10			
	SUN BOND HF 550LH	4.00 x 450	8			
	SUN BOND HF MANGAN	5.00 x 450	6			
Stainless Steel Electrodes (Available in Vacuum Pack)	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND E308L	1.60 x 250	16	1.5 Kgs	5	7.5 Kgs
		2.00 x 300	14	2 Kgs	5	10 Kgs
	SUN BOND E309L	2.50 x 350	12			
		3.15 x 350	10			
	SUN BOND E316L	4.00 x 350 5.00 x 350	8 6			
Pipe Welding Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND E6010	2.50 x 350 3.15 x 350 4.00 x 350 5.00 x 350	12 10 8 6	5 Kgs	4	20 Kgs
Cutting Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND CUTROD	2.50 x 350	12	5 Kgs	4	20 Kgs
		3.15 x 350	10			
		4.00 x 350/450	8			
		5.00 x 450	6			
Cast Iron - Non Machinable Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND CINM	3.15 x 350 4.00 x 350 5.00 x 350	10 8 6	1 Kgs	20	20 Kgs
Cast Iron - Machinable Electrodes	Product Name	Available Sizes (mm)	SWG (Guage)	Kgs Per Packet	Packets Per Box	Total Box Weight (Kgs)
	SUN BOND CIFN	3.15 x 350	10	1 Kgs	12	12 Kgs
	SUN BOND CINI	4.00 x 350	8			
	SUN BOND CI MONEL	5.00 x 350	6			



SB TIG 70S-2

Copper Coated wire for TIG welding

CHARACTERISTICS :

Triple deoxidized copper coated C-Mn steel filler rod High quality, high toughness welds it will give radiographic quality welds with minimum spatter and smooth flow, stable arc under optimum conditions.

TYPICAL APPLICATIONS:

Suitable for welding structural steel, Pressure vessel, Boilers involving unalloyed and micro-alloyed structural steels with specified UTS upto 520 Mpa to meet impact requirements at -30° C. Best suited for single side, melt through welding. High quality pipe welding of mild and medium tensile steels is ideal for root passes in thick walled material.

GTAW



CLASSIFICATION :		WELDING POSITION :		STORAGE / HANDLING :	
AWS	A5.18 ER70S-2	SHIELDING GAS	Argon gas	Keep dry during storage and handling	
EN ISO 636-A	W 42 3 W2Ti	GAS FLOW RATE, LPM	8 - 15		

CURRENT CONDITION : DCEN					
SIZE (mm)	Ø 1.60	Ø 2.00	Ø 2.40	Ø 3.20	Ø 4.00
CURRENT (amps)	40 - 80	50 - 100	60 - 120	100 - 150	140 - 200

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :													
ELEMENT	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	V	Ti	Zr	Al
PERCENT (Max)	0.07	0.90 - 1.40	0.40 - 0.70	0.035	0.025	0.15	0.15	0.15	0.5	0.03	0.05 - 0.15	0.02 - 0.12	0.05 - 0.15

* Including Cu in the coating

MECHANICAL PROPERTIES OF ALL WELD METAL :					
	Condition	UTS (Mpa)	Y.S (Mpa)	Elongation %	Impact at -30°C
Specification	As Welded	500 min	420 min	22 min	28 J

PACKING DATA :				
SB TIG 70S-2	SIZE (mm)	Plastic Tube / Kg	No. of Plastic Tube / Box	Net Wt. of Box (Kg)
	1.60 x 1000	5	5	25
	2.00 x 1000	5	5	25
	2.40 x 1000	5	5	25
	3.20 x 1000	5	5	25
	4.00 x 1000	5	5	25

ACCURA WELDRODS Kovai Pvt Ltd

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MADE IN INDIA

COPPER COATED MILD STEEL (CCMS)

Copper Coated Mild Steel is a general purpose low carbon steel rod for high grade oxyacetylene welding of mild steel and wrought iron. It is widely used in the automobile, heating and ventilation and chemical plant industries.

Advantages :

No flux is required. The rods melt at 1490°C.

Chemical Composition :

C	Si	Mn	S	P	Ni	Cu
0.12	0.10	0.60	0.040	0.040	0.025	0.45

Packing Details :

Size (mm)	Net Wt. / Tube (kg)	Gross Wt. / Tube (kg)	Approx. No. of Wire Rods in 25 kg Paper Tube
1.60 x 1000	25	25.750	1575 to 1600
1.60 x 805	20	20.750	1590 to 1610



Current Range : As per User Application.



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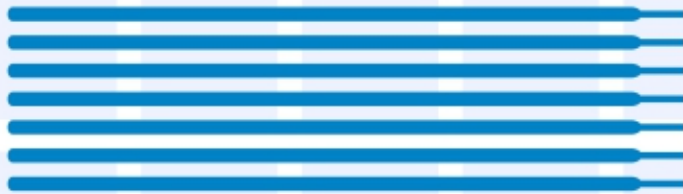


ACCURA WELDRODS Kovai Pvt Ltd

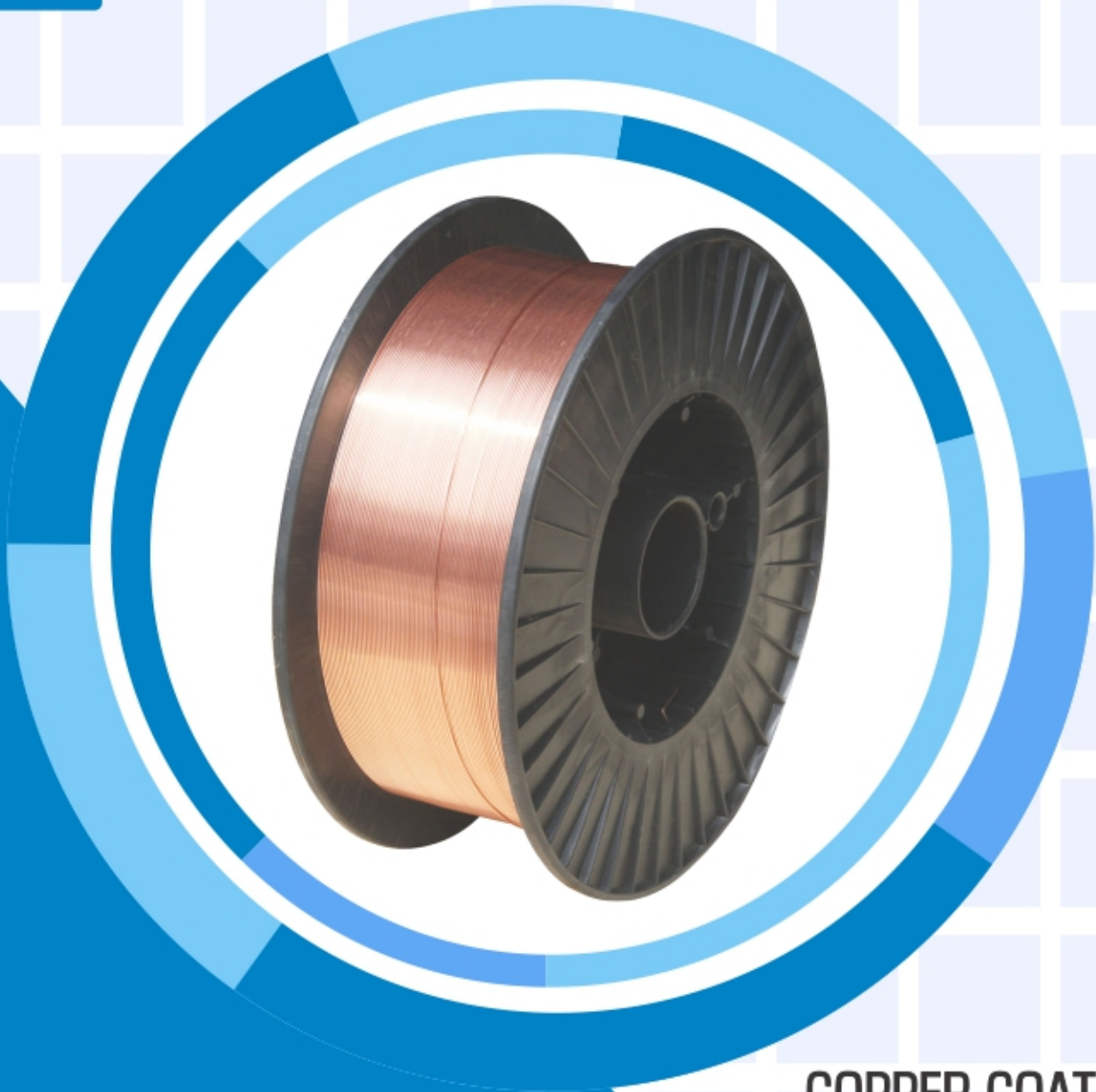
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GMAW



**COPPER COATED
MILD STEEL
MIG WELDING WIRE
ER70S-6**

ACCURA WELDRODS Kovai Pvt Ltd

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Accura Weld rods Kovai Private Ltd (AWR) an ISO 9001 :2008 and 14001 :2004 Certified Company offers wide range of welding electrodes for various applications in industries like fabrication, shipbuilding, construction, civil engineering, machinery and automobile manufacture. We are one of the finest companies who are keen in delivering quality products.

Applications

- ◆ Automobile Body, Chassis, Frames and Brackets.
- ◆ Automobile Silencers, Petrol / Diesel / Gas Tanks all other Automobile, Scooter, Cycle spare parts and accessories.
- ◆ SAW Pipes, LPG Gas Cylinders, Compressors, Railway Wagons, Boilers, Poles & Steel Towers.
- ◆ Steel Furniture, scaffolding & all other welding in general steel fabrication.

Classification

Size (mm) : 0.80, 1.00, 1.20, 1.60.

Grade : AWS-ER 70S6, DIN-SG2, IS-6419-S4

Packaging : 15 kg (also available in 1 & 5 kg) in DIN 300 mm plastic spools 100% precision layer winded

Chemical Analysis % : (Typical Values)

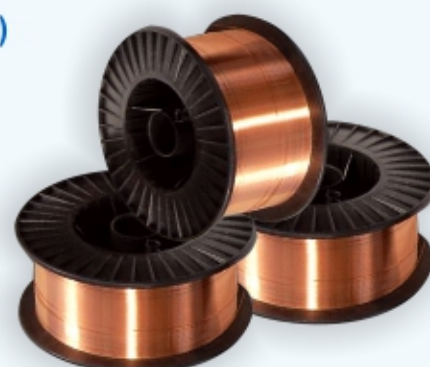
C %	Mn %	Si %	S %	P %	Cr %	Ni %	V %	Mo %	Cu %
0.06 - 0.15	1.40 - 1.85	0.80 - 1.15	0.35 Max	0.025 Max	0.15 Max	0.15 Max	0.03 Max	0.15 Max	0.50 Max

Mechanical Properties of the Pure Weld Metal (Typical Values)

U.T.S (N/mm ²)	Y.S (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30°C(J)
490	400	22	27

Packaging and Welding Current

Size (mm)	Current (Amps)	In Amps	In Volts	GAS FLOW L/M
0.8	DC (+)	50 - 180	18 - 25	10 - 25
1.0		80 - 200	20 - 26	12 - 20
1.2		130 - 300	22 - 36	15 - 25
1.6		150 - 500	24 - 36	15 - 30



Co2 MIG WIRE

ACCURA WELDRODS Kovai Pvt Ltd

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MILD STEEL FILLER WIRE (MS)

Mild Steel is a general purpose low carbon steel rod for high grade oxyacetylene welding of mild steel to mild steel. Widely used in automobile, heating and ventilation and chemical plant industries.

Advantages :

Weld in all positions, Clean weld - No flux is required.

Chemical Composition :

C	Si	Mn	S	P	Cu	V	Ti	Al
0.10	0.03	0.38-0.62	0.030	0.030	0.15	0.005	0.003	0.012

Packing Details :

Size (mm)	Net Wt. / Tube (kg)	Gross Wt. / Tube (kg)	Approx. No. of Wire Rods in 25 kg Paper Tube
2.00 x 1000	25	25.700	975 to 1000
2.50 x 1000	25	25.700	640 to 650
3.15 x 1000	25	25.700	410 to 420
4.00x 1000	25	25.700	245 to 255

Current Range : As per User Application.



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MADE IN INDIA



STAINLESS STEEL ELECTRODE



SUNBOND E308

CODIFICATION: AWS A5.4 : E308-16

IS 5206 : E19.9.R26

CHARACTERISTICS & APPLICATIONS

A rutile coated stainless steel electrode. It gives smooth and shiny weld bead with easily removable slag. It gives radiographic welds with excellent creep strength. For welding of AISI 301, 302, 304 & 308 steels, household articles, hospital apparatus, kitchen equipments etc.

TYPICAL CHEMICAL COMPOSITION OF ALLWELD METAL:

Element	C	S	Mn	Si	P	Cr	Ni	Mo	Cu
Percent	0.06	0.01	0.5-2.50	0.75	0.03	18-21	9-11	0.75	0.75

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %
550-650	35

CURRENT CONDITION : AC/DC(+)

Size (mm)	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

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SUNBOND E308 L

CODIFICATION : AWS A5.4 : E308L-16

IS 5206 : E19.9.LR26

CHARACTERISTICS & APPLICATIONS

A rutile coated stainless steel electrode. It gives smooth and shiny weld bead with easily removable slag. It gives radiographic welds with excellent creep strength. For welding of AISI 301, 302, 304L & 308L steels, household articles, hospital apparatus, kitchen equipments etc.

TYPICAL CHEMICAL COMPOSITION OF ALLWELD METAL:

Element	C	S	Mn	Si	P	Cr	Ni	Mo	Cu
Percent	0.024	0.020	0.50-2.00	0.70	0.03	18-21	9-11	0.75	0.75

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %
550 - 600	35

CURRENT CONDITION : AC/DC(+)

Size (mm)	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

Precautions: Re-dry the electrodes at 250°C for one hour before to use.

SUNBOND E316 L

CODIFICATION : AWS A5.4 : E316L-16

IS 5206 : E19.9.2LR26

CHARACTERISTICS & APPLICATIONS

A rutile coated stainless steel 316L type electrode. It gives smooth and shiny weld beads with excellent mechanical properties. The weld metals are highly resistant to corrosion and scaling temperatures up to 850°C. It deposits Mo - stabilized welds of radiographic welds with excellent creep strength. For welding of AISI 316, 316L, 317 paper and pulp industries, chemical industries, fertilizer plants, paint and dye industries etc.

TYPICAL CHEMICAL COMPOSITION OF ALLWELD METAL:

Element	C	S	Mn	Si	P	Cr	Ni	Mo	Cu
Percent	0.040	0.020	0.50-2.00	0.75	0.03	17-20	11-14	2.0-3.0	0.75

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %
520 - 600	30

CURRENT CONDITION : AC/DC(+)

Size (mm)	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

Precautions: Re-dry the electrodes at 250°C for one hour before to use.

SUNBOND E309 L

CODIFICATION : AWS A5.4 : E309L-16

IS 5206 : E23.12.LR26

CHARACTERISTICS & APPLICATIONS

A rutile coated stainless steel type electrode depositing an extra low carbon 25/12 weld metal. The weld metal has excellent corrosion and oxidation resistance at high temperatures. Welds are radiographic quality. Suitable for welding of AISI type 309, 309L steels, straight chrome steels joining of dissimilar steels and for overlays on mild steels.

TYPICAL CHEMICAL COMPOSITION OF ALLWELD METAL:

Element	C	S	Mn	Si	P	Cr	Ni	Mo	Cu
Percent	0.04	0.01	0.50-2.00	0.70	0.03	22-25	12-14	0.70	0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %
520 - 650	30

CURRENT CONDITION : AC/DC (+)

Size (mm)	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

Precautions: Re-dry the electrodes at 250°C for one hour before to use.



STAINLESS STEEL WIRE FOR TIG WELDING



SB TIG 304L

Stainless Steel wire for TIG welding

CHARACTERISTICS :

An extra-low carbon filler wire for the welding of type 304L, 321 and 347 stainless steels. The controlled ferrite content in weld ensures excellent crack resistance. Provides excellent notch toughness at very low temperatures and low carbon reduces the possibility of intergranular carbide precipitation and therefore it increases the resistance to intergranular corrosion. Radiographic quality welds

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

ELEMENT	C	Mn	Si	S	P	Cr	Ni
PERCENT (Max)	0.03	2.000	1.000	0.030	0.045	18.00 - 20.00	8.00 - 12.00

TYPICAL APPLICATIONS:

Suitable for Welding Cr-Ni steels represented by AISI 301, 302, 304 and 304L grades, etc. Suitable for welding of piping systems, tubes, boilers in chemical and food processing industries carbon 19%Cr-9%Ni steel for Automobiles and Chemical Industries such as oil, Medical, Fertilizer Textile and Railway Industries and For Nuclear reactors

MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (Mpa)	Elongation %
520 min	35 min

SB TIG 308L

Stainless Steel wire for TIG welding

CHARACTERISTICS :

An extra low carbon 19Cr/9Ni type stainless steel solid wire Excellent corrosion & scaling resistance up to 800°C Resistance to intergranular corrosion Excellent crack resistance, Radiographic quality welds, Excellent crack resistance.

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

ELEMENT	C	Mn	Si	S	P	Cr	Ni
PERCENT (Max)	0.03	1.00 - 2.50	1.000	0.030	0.030	19.00 - 22.00	9.00 - 12.00

CLASSIFICATION :

AWS	A5.9 ER308L
EN ISO 14343-A	W 19 9 L

TYPICAL APPLICATIONS:

Suitable for welding wire of 19%Cr-9%Ni steel for Automobiles and Chemical Industries such as oil, Medical, Fertilizer Textile and Railway Industries and For Nuclear reactors. Designed for welding SS 301, 302, 304, 304L, 308, 308L, 321 and 347 grades. Used in chemical plants, fertilizer plants, oil refineries, food & dairy industries. Also used for making furniture, hospital and kitchen equipment.

MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (Mpa)	Elongation %
520 min	35 min

SB TIG 309L

Stainless Steel wire for TIG welding

CHARACTERISTICS :

An extra low carbon 23Cr/12Ni type stainless steel wire excellent corrosion and oxidation resistance upto 1100°C High ferrite content ensures highest cracking resistance with Radiographic quality welds.

CLASSIFICATION :

AWS	A5.9 ER309L
EN ISO 14343-A	W 23 12 L

TYPICAL APPLICATIONS:

Suitable for welding wire of 22Cr-12Ni steel for joining ferrite to austenite stainless steel for services temperature upto 300°C. Dissimilar joints between stainless steel and low alloy or carbon steels. Heat resistance cast steel clad side of 18% Cr-8% Ni clad steel and stainless steel to Cr-Mo steel or carbon steel. Buffer layer on low alloy and carbon steels.

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

ELEMENT	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
PERCENT (Max)	0.03	1.00 - 2.50	0.30 - 0.65	0.030	0.030	23.00 - 25.00	12.00 - 14.00	0.75	0.75

MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (Mpa)	Elongation %
520 min	30 min

SB TIG 316L

Stainless Steel wire for TIG welding

CHARACTERISTICS :

An extra low carbon 19Cr/12Ni/Mo type stainless steel wire. Offers improved corrosion and pitting resistance in marine and industrial environment. High resistance against inter granular corrosion. Resistant to SCC, hot cracking and chemical attack upto 850°C with Radiographic quality welds.

CLASSIFICATION :

AWS	A5.9 ER316L
EN ISO 14343-A	W 19 12 3 L

TYPICAL APPLICATIONS:

Suitable for Welding austenitic alloys represented by AISI 316, 316L, 317, 317L, 318 types. Application in textile processing, Paper and pulp, Paint and dye industries, Naval and Chemical environments, Cladding stainless steels. Joining similar grade wrought and cast material.

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

ELEMENT	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
PERCENT (Max)	0.03	2.00	0.30 - 0.65	0.030	0.030	19.00 - 22.00	9.00 - 12.00	0.75	0.75

MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (Mpa)	Elongation %
490 min	30 min

PACKING DATA :

SB TIG 304L / 308L / 309L / 316L	SIZE (mm)	Plastic Tube / Kg	No. of Plastic Tube / Box	Net Wt. of Box (Kg)
	1.60 x 1000	5	5	25
	2.00 x 1000	5	5	25
	2.50 x 1000	5	5	25
	3.20 x 1000	5	5	25
	4.00 x 1000	5	5	25

SB TIG 202

Stainless Steel wire for TIG welding

CHARACTERISTICS :

TIG 202—austenitic general purpose stainless steel with chromium-nickel-manganese stainless steel that was developed originally to conserve nickel 202 is basically a cheaper alternative to SS 304 for applications like kitchen sinks, utensils etc.

Packing Data : Available Only in 25 Kgs

TYPICAL APPLICATIONS:

General purpose stainless steel for welding Furniture Bins Cookware & Serving Bowls Window Channel Spacers Safety Shoes (mid-sole protector) Deep drawn kitchen equipment – e.g. Cookware & Sinks Hose Clamps Trailer Frames Industrial Strapping Railway Rolling Stock Examples include sides & roofs of trains, liquified gas storage vessels, structural members/chassis of railway rolling stock, trucks & trailers, coal handling equipment

WELDING POSITION :

SHIELDING GAS	Argon gas
GAS FLOW RATE, LPM	10 - 15

CURRENT CONDITION : DCEN

SIZE (mm)	Ø 1.60	Ø 2.00	Ø 2.50	Ø 3.20	Ø 4.00
CURRENT (amps)	40 - 80	50 - 100	60 - 120	100 - 150	140 - 200

STORAGE / HANDLING :

Keep dry during storage and handling

ACCURA WELDRODS Kovai Pvt Ltd

No.1/15-2, PONNANDAMPALAYAM, S.F.No.454 PART 475/2, KANIYUR VILLAGE, COIMBATORE - 641 659, TAMIL NADU, INDIA.

E-mail: info@sunbond.in | Website: www.sunbond.in | Phone: +91 97888 55677 | Customer Care : +91 94421 62983

MADE IN INDIA

SUN BOND[®] BINDING WIRE

CHARACTERISTICS

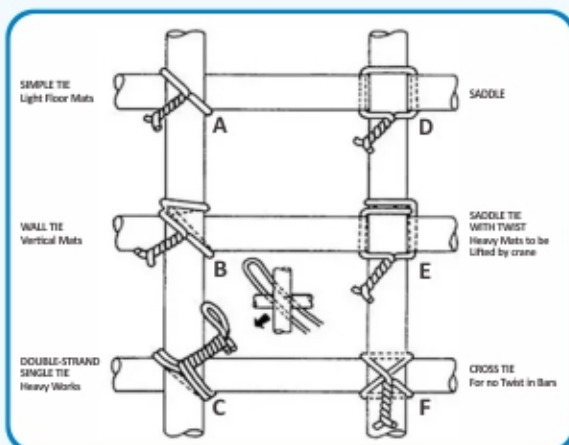
SUN BOND BINDING WIRE are soft annealed black wire is made of carbon steel wire, it has high reliable strength, ductility, soft, flexible to handle easily and strong enough to hold the rebar's in the construction field. **SUN BOND BINDING WIRES** available in uniform size, weight and scale free with good surface finishing. Secure packing to protect wire from rust and ease to handle.

APPLICATIONS

It is used extensively in the construction sector for tying the rebar's at the joints to keep the structure intact binding wire are flexible enough to tie easily and strong enough so as to hold the joint in place. They are used for tying the joints various methods shown in below figure.



SOME OF TYING METHODS



TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT :	C	Mn	Si	S	P
PERCENT (Max) :	0.10	0.30-0.50	0.20	0.035	0.035

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

Condition	UTS (N/mm ²)
Annealed	550 max

PACKING DETAILS

Dia (mm)	0.82 - 0.89			
Weight / Coil (Kg)	10*	25	50*	100*

* Manufactured against order only

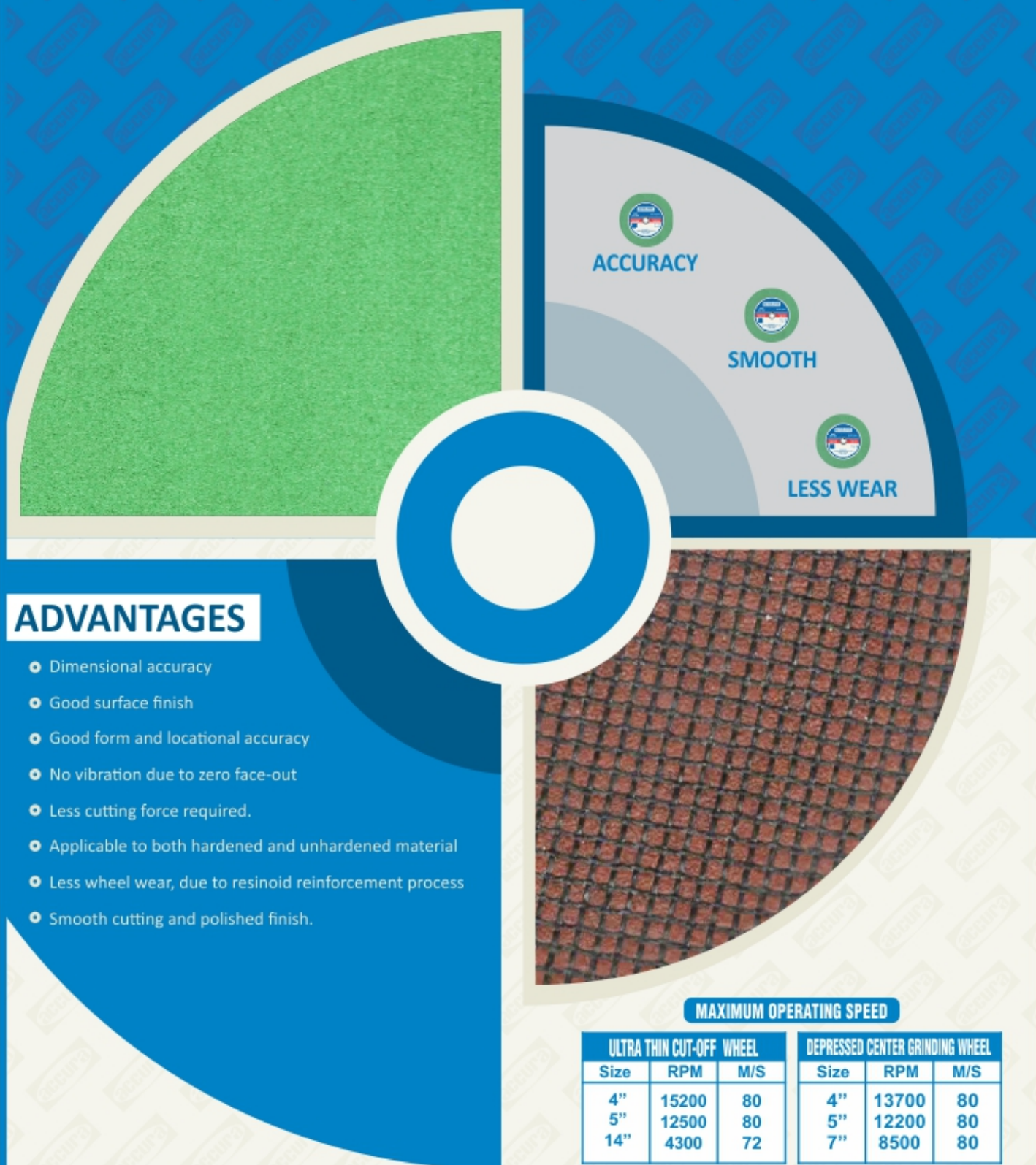
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MADE IN INDIA

ULTRA THIN CUT-OFF WHEEL & DEPRESSED CENTER GRINDING WHEEL



ADVANTAGES

- Dimensional accuracy
- Good surface finish
- Good form and locational accuracy
- No vibration due to zero face-out
- Less cutting force required.
- Applicable to both hardened and unhardened material
- Less wheel wear, due to resinoid reinforcement process
- Smooth cutting and polished finish.

MAXIMUM OPERATING SPEED

ULTRA THIN CUT-OFF WHEEL			DEPRESSED CENTER GRINDING WHEEL		
Size	RPM	M/S	Size	RPM	M/S
4"	15200	80	4"	13700	80
5"	12500	80	5"	12200	80
14"	4300	72	7"	8500	80

Manufactured by:

ACCURA WELDRODS Kovai Pvt Ltd

No.1/15-2, PONNANDAMPALAYAM, S.F.No.454 PART 475/2, KANIYUR VILLAGE, COIMBATORE - 641 659. TAMIL NADU, INDIA.

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INTRODUCTION

Grinding is the most common form of abrasive machining. It is a material cutting process which engages an abrasive tool whose cutting elements are grains of abrasive material known as grit. These grits are characterized by sharp cutting points, high hot hardness, chemical stability and wear resistance. The grits are held together by a suitable bonding material to give shape of an abrasive tool. Such wheels are used in grinding & cutting operations.

The wheels are generally made from a composite material consisting of coarse-particle aggregate pressed and bonded together by a cementing matrix (called the bond in grinding wheel terminology) to form a solid, circular shape.

CHARACTERISTICS OF WHEEL

There are five characteristics of a cutting wheel:

- Material (Al_2O_3 , SiC, Ceramic, Diamond, CBN)
- Grain size (10 [Coarsest] to 600 [Finest])
- Wheel grade (A [Soft] to Z [Hard])
- Bond type (V, R, BF, S, E, R, M)
- They are indicated by codes on the wheel's label.

APPLICATIONS

Cutting Process (Cut-Off Wheels):

- Ultra-thin wheel range of products are specially designed for burn and burr free cutting applications.
- Large diameter cut-off wheels are mainly used for Cutting of large diameter bars, pipe cutting and in steel industry to cut different cross sections.

Grinding Process (Grinding Wheels):

- Grinding is an abrasive machining process that uses a grinding wheel or grinder as the cutting tool.
- Grinding is used to finish workpieces that must show high surface quality and high accuracy of shape and dimension. It has some roughing applications in which grinding removes high volumes of metal very rapidly.



PACKING LIST

Type of Wheel	Product Name	Dimensions (mm)	Size (Inch)	Color	Pieces Per Tube/Pack (No's)	Tubes / Pack per Box (No's)	Pieces per Box (No's)
Ultra Thin Wheel	Ultra Thin Cut-Off Wheel	107 x 16 x 1.2	4	Green, Brown, Black	100	6	600
	Ultra Thin Cut-Off Wheel	125 x 22.23 x 1.2	5	Green, Brown, Black	100	6	600
	Resinoid Cut-Off Wheel	355 x 25.4 x 2.8	14	Green, Brown, Black	5	5	25
	Double Net Cut-Off Wheel	355 x 25.4 x 3.2	14	Green, Brown, Black	5	5	25
Grinding Wheel	Depressed Center Grinding Wheel	100 x 16 x 6	4	Brown	25	6	150
	Depressed Center Grinding Wheel	125 x 22.23 x 6	5	Brown	20	6	120
	Depressed Center Grinding Wheel	180 x 22.23 x 6/7	7	Brown	5	5	25

Manufactured by:

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