



TENALLOY 16 SPL

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 **E7016-1**

CLASSIFICATION:

ISO 2560-A
E 42 5 B 12 H5

KEY FEATURES:

- Medium coated basic electrode
- Moisture resistant coating
- Weld metal resistant to cold and hot cracking and tri-axial stressings
- Positional welding characteristics with medium coating ideal for full penetration root run in pipe welding
- DCEN preferred for root run welding of pipes

APPROVALS: - LRA/CE

TYPICAL APPLICATIONS:

- Root welding of pipes in 6G position
- Horton spheres, Penstocks
- Carbon steel and low alloy steel pressure vessels fabrications and where severe service conditions exists
- For NACE quality carbon steel pipes
- Off-shore process platform structures
- Medium, high tensile structural steels
- Heavy sections and restrained joints in high tensile structural steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.45	0.3


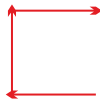
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -46°C, J
Typical	As Welded	570	490	25	100
Specification		490 min	400 min	22 min	60 min

Hardness (3 Layer): 200BHN max

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 / DCEN REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, Except Vertical Down 
3.15 x 350	90-150		
3.15 x 450	90-140		
4.0 x 450	140-180		
5.0 x 450	180-250		

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