

TENALLOY 16

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 **E7016**

CLASSIFICATION:

ISO 2560-A E 42 3 B 12 H5

IS 814 EB5426H₃X

KEY FEATURES:

- Basic coated low hydrogen electrode
- Ductile weld metal provide superior crack resistance
- All position capability
- Excellent impact properties down to -30°C
- Radiographic weld deposit

APPROVALS: ABS/DNV/IRS/LRA/IBR/CE/RDSO

TYPICAL APPLICATIONS:

- Buffer layer before hard facing
- Joining cast iron to mild steel
- Repair of cast iron

- Butt welding of rail ends
- Fixing of rails to mild steel girders

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C | Mn | Si 0.06 | 1.2 | 0.6

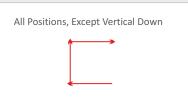
MECHANICAL PROPERTIES OF ALL WELD METAL:					
	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J -30°C
Typical	As Welded	560	475	27	60
Specification		490 min	400 min	22 min	50 min

Hardness (3 Layer): 200 BHN max.

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350	Amperage, A 60-80	4 DCEP			
3.15 x 350	90-120				
3.15 x 450	90-120	REDRYING CONDITION:			
4.0 x 450	130-170	250-300°C for minimum 1 hr.			
5.0 x 450	180-230				



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