



# TENALLOY 70CL

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E7018-C3L

### CLASSIFICATION:

EN ISO 2560-A  
E 38 5 1Ni B 32 H5

### KEY FEATURES:

- Basic coated low carbon electrode
- Typical Ni-Mo type welds
- Excellent fracture toughness at -50°C
- Superior crack resistance
- Radiographic quality welds
- All position capability

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of high tensile steels and fine grained steels like HY 80, HY 90, HY 100
- Storage tanks for low temperature
- Off shore platforms, bridge
- Application in refineries, power plants e.g. pressure vessels and heat exchangers, machinery

### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Ni
0.04	1.0	0.3	1.0

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	530	440	26	70
Specification		490 min	400 min	22 min	47 min

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 All Positions, except vertical Down  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.
3.15 x 450	100-140	
4.0 x 450	140-180	
5.0 x 450	190-250	

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