



TENALLOY 90P2

LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.5 **E9045-P2 H4R**

CLASSIFICATION:

EN ISO 2560-A
E 50 5 1Ni B 4 5

KEY FEATURES:

- Basic coated electrode
- Easy to use with controllable slag system
- Deposit is extremely crack resistant
- Deposition rate is higher than for vertical up welding
- High toughness and a very low hydrogen content
- Exceptional striking characteristics
- Suitable for filler and cover pass welding in pipeline construction

TYPICAL APPLICATIONS:

- Vertical-down welds of large diameter pipelines and for structural work
- It can be used in sour gas application
- Fill and cap application
- Circumferential joints in pipelines API 5LX70, X80

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


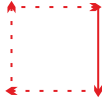
C	Mn	Si	Mo
0.09	1.5	0.6	0.35

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	690	590	23	60
Specification		620 min	530 min	17 min	47 min

Diffusible H2 Content: <4 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, specifically in vertical down 
3.15 x 350	90-140		
4.0 x 350	140-180		

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