



TENALLOY R

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 E7018-G

CLASSIFICATION:

ISO 2560-A

E 42 5 B 32 H5

IS 814

EB5629H,JX

KEY FEATURES:

- Basic type iron powder electrode
- Deposition efficiency approx 110%
- Exhibit excellent impact at subzero temperatures
- All position capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Ammonia storage tanks
- Horton spheres, Pressure vessels
- Si-Mn steels
- Steels containing Ni upto 1%
- For mild steel and heavy joints at subzero temperatures
- Joining ASTM SA 515/515M Gr.60/65, SA 516/516M Gr.60/65 steels


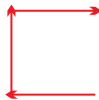
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.2	0.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact -50°C, J
Typical	As Welded	550	480	27	55
Specification		490 min	400 min	22 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV)/ DCEP All Positions, Except Vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	90-140	
4.0 x 450	140-180	
5.0 x 450	180-240	

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