



TENALLOY S PLUS

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 E7018-1 H4R

CLASSIFICATION:

ISO 2560-A
E 42 5 B 32 H5
IS 814
EB5629H₃JX

KEY FEATURES:

- Basic coated iron powder type
- Excellent toughness down to -60°C
- Radiographic weld deposit
- Suitable for pipe welding in 5G and 6G positions

APPROVALS: ABS/DNV/LRA/IBR/CE

TYPICAL APPLICATIONS:

- Storage tanks, pipes, boilers
- Bridges & heavy structures subject to dynamic loading
- Joining ASTM SA 414/414M Gr.C/D,SA 516/516M Gr.55/60/65/70, IS 2002, IS 2062 steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.5	0.3


MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact
					-46°C, J
Typical	As Welded	550	470	28	100
Specification		490 min	400 min	22 min	80 min


Hardness (3 Layer): 200 BHN max
Diffusible H2 Content: <5 ml/100 gm

Special Test: HIC and SSCC (NACE), CTOD at -10°C
Hot tensile at 200°C

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.
3.15 x 350	90-140	
3.15 x 450	90-140	
4.0 x 450	140-180	
5.0 x 450	180-240	

All Positions, Except Vertical Down



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

EQUIVALENT:

GTAW	FCAW	SAW	
		Flux	Wire
Tigfil 70S-2 SPL	Automig FC 71T-5	Automelt B20 Plus	Automelt EH12K
Tigfil 70S-3	-	Automelt B41	Automelt EH10K
Tigfil 70S-6	-	Automelt B41	Automelt EH14