TENALLOY 70C

CLASSIFICATIONS
AWS A/SFA 5.5 E 8018-C3
IS 1395 E 55 BC 329 Fe

COATING TYPE: Basic DEPOSITION EFF., %: ~110

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

APPROVALS
ABS E 8018-C3

CURRENT CONDITIONS: AC, DC (+)

6.3	5.0	4.0	3.2	2.5
260-310	190 - 250	140-180	100-140	60-90

CHARACTERISTICS
A low-hydrogen, iron-powder electrode for welding of <1.0% Ni steels. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

WELDING POSITIONS
F, H, V-up, OH

REDRYING CONDITIONS
300^{0}C for 1 Hr (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS
Welding of ~1.0% Ni steels in refineries, power plants e.g. pressure vessels and heat exchangers.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts,J -40^{0}C	CVN Impacts,J -50^{0}C	Hardness, BHN
AW	560-650	460-550	24-30	50-100	40-90	200 max.

AW : As-welded

WELD METAL CHEMISTRY, wt%

C - 0.05-0.09	S - 0.030 max.	Diffusible H_2
Mn - 0.80-1.25	P - 0.030 max.	Content ml/100gm
Mo - 0.20-0.35	Ni - 0.80-1.10	<5
Si - 0.20-0.45		

PACKING DATA

Dia.,mm	5.0	4.0	3.2	3.2
Length,mm	450	450	450	350
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
Wt. per box, kgs	21	21	21	21

Related Products: Tigfil-Ni1, Tenalloy-Ni, Automig FC 410, AutomeIt FC 410 + B41 flux