

TENALLOY 16 SPL

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 **E7016-1**

CLASSIFICATION:

ISO 2560-A E 42 5 B 12 H5

KEY FEATURES:

- Medium coated basic electrode
- Moisture resistant coating
- Weld metal resistant to cold and hot cracking and tri-axial stressings
- Positional welding characteristics with medium coating ideal for full penetration root run in pipe welding
- DCEN preferred for root run welding of pipes

APPROVALS: - LRA/CE

TYPICAL APPLICATIONS:

- Root welding of pipes in 6G position
- Horton spheres, Penstocks
- Carbon steel and low alloy steel pressure
 Medium, high tensile structural steels vessels fabrications and where severe service conditions exists
- For NACE quality carbon steel pipes
- Off-shore process platform structures

 - Heavy sections and restrained joints in high tensile structural steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C Mn Si 0.06 1.45

| MECHANICAL PR | OPERTIES OF ALL WE | LD METAL: | | | |
|---------------|--------------------|-----------|---------------------------|--------|---------------------------|
| | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact at -46°C, J |
| Typical | As Welded | 570 | 490 | 25 | 100 |
| Specification | | 490 min | 400 min | 22 min | 60 min |

Hardness (3 Layer): 200BHN max

Diffusible H2 Content: <5 ml/100 gm

| PARAMETERS - PACKING DATA: |
|----------------------------|
|----------------------------|

| 7,10,111,12,12,10 | | | | | | |
|--|--|---|--|--|--|--|
| Ø x L, mm 2.5 x 350 3.15 x 350 3.15 x 450 4.0 x 450 5.0 x 450 | Amperage, A 60-90 90-150 90-140 140-180 180-250 | AC (70 OCV)/ DCEP / DCEN REDRYING CONDITION: 250-300°C for minimum 1 hr. | | | | |

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

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