



TENALLOY 16 SPL

C-Mn STEEL (Low Hydrogen)



Welding Electrode specially for Nace Quality Carbon Steel Welding

CLASSIFICATION : ISO 2560-A

AWS A/SFA 5.1

E 42 5 B 12 H5

E 7016-1

KEY FEATURES :

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

WELDING POSITION :



AC (60 OCV) / DCEP / DCEN

TYPICAL APPLICATIONS :

- One side welding of pipes
- Horton spheres, Penstocks
- Carbon steel and low alloy steel pressure vessels fabrications and where severe service conditions exist
- For NACE quality carbon steel pipes
- Off-shore process platform structures
- Medium, high tensile structural steels
- Heavy sections and restrained joints in high tensile structural steels

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.07	1.2	0.3	0.01	0.01
Specification	0.15 max	1.6 max	0.75 max	0.035 max	0.035 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	550	470	25	52
Specification		490 min	400 min	22 min	40-60

Diffusible H₂ Content: <5 ml/100 gm

SPECIAL TEST : HIC & SSCC (NACE). HIC & SSCC (NACE), CTOD at -10°C

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	281	4	17
3.15 x 450	90-140	132	4	37
4.0 x 450	140-180	85	4	58
5.0 x 450	180-250	55	4	90