



TENALLOY 120

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E12018-M**

CLASSIFICATION:

EN ISO 18275-A
E 69 4 Z B 32 H5

KEY FEATURES:

- Basic type coating
- Ni-Mn-Mo-Cr alloyed electrode
- Excellent crack resistance
- Excellent toughness at subzero temperature
- Radiographic quality weld metal

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of high tensile steels and fine grained steels like HY 80, HY 90, HY 100
- Joining high strength, low alloy or microalloyed steels to themselves or to lower strength steels, including carbon steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


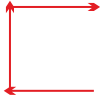
C	Mn	Si	Cr	Ni	Mo
0.065	1.9	0.3	0.4	2.2	0.35

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	900	800	19	60
Specification		830 min	735 - 830	18 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP	All Positions, except vertical Down 
3.15 x 450	100-140		
4.0 x 450	140-180		
5.0 x 450	180-250		
		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