



TENALLOY 120G

LOW ALLOY STEEL (High Strength)



Welding Electrode for Joining High Strength Steel

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
- High strength and toughness at -50°C
- Radiographic weld quality

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

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

REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	Mo
Typical	0.05	1.80	0.4	2.2	0.4

	Cr	V	S	P	
Typical	0.4	0.01	0.015	0.015	

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	870	780	20	50

Diffusible H₂ Content: <5 ml/100 gm

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	215	4	23
3.15 x 450	100-140	113	4	44
4.0 x 450	140-180	78	4	63
5.0 x 450	190-250	51	4	96