



TENALLOY 125

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

E3580-A

E CrMoV1 B 22 H5

KEY FEATURES:

- Basic coated electrode
- Cr-Mo-V type low alloy weld deposit
- Suitable for welding similar composition cast steels
- The deposit is heat treatable
- All position capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding similar composition low alloy cast steels e.g. (GS-17CrMoV5-10)
- Suitable for steel casting with comparable hardening characteristics
- Suitable for material 1.7706

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo	V
0.12	0.8	0.4	1.3	1.15	0.25



MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	PWHT*	715	620	20	82
Specification		630 min	500 min	16 min	47 min

*PWHT : SR at 690°C for 2 hrs followed by water quenching after soaking at 940°C for 1 hr and tempering at 720°C.

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	100-130	
4.0 x 450	140-180	
5.0 x 450	190-230	

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