



## TENALLOY 16

C-Mn STEEL (Low Hydrogen)



Special Welding Electrode for Buffer Layer and Repair Welding

**CLASSIFICATION : ISO 2560-A**

**AWS A/SFA 5.1**

**IS 814**

E 42 3 B 12 H5

E 7016

E B5426H<sub>3</sub>X

ABS/BV/DNV/IRS/LRA/IBR

### KEY FEATURES :

- Basic coated low hydrogen electrode
- Ductile weld metal provide superior crack resistance
- All position capability
- Excellent impact properties down to -30°C
- Radiographic weld deposit

### WELDING POSITION :



AC (70 OCV)/ DCEP

### TYPICAL APPLICATIONS :

- Buffer layer before hardfacing
- Joining cast iron to mild steel
- Repair of cast iron
- Butt welding of rail ends
- Fixing of rails to mild steel girders

**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	S	P
Typical	0.06	1.2	0.5	0.02	0.02
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 , J	
					27°C	-30°C
Typical	As Welded	560	475	27	160	63
Specification		490 min	400 min	22 min.	140-200	50-80

**Hardness, 3 Layers: 200 BHN max.**

**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	60-80	287	4	17
3.15 x 450	90-120	133	4	37
4.0 x 450	130-170	86	4	58
5.0 x 450	180-230	54	4	91