

TENALLOY 16

AWS A/SFA 5.1 E7016

C-Mn STEEL (Low Hydrogen)

CLASSIFICATION:

ISO 2560-A
E 42 3 B 12 H5

IS 814
E B5426H₃X

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

APPROVALS: ABS/DNV/IRS/LRA/IBR/CE/RDSO

TYPICAL APPLICATIONS:

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.2	0.6


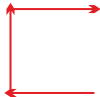
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J
					-30°C
Typical	As Welded	560	475	27	60
Specification		490 min	400 min	22 min	50 min

Hardness (3 Layer): 200 BHN max.

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 DCEP	All Positions, Except Vertical Down: 
2.5 x 350	60-80		
3.15 x 450	90-120		
4.0 x 450	130-170		
5.0 x 450	180-230		

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

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