ador
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TENALLOY 16E SPL

LOW ALLOY STEEL (Low Temperature)

Welding Electrode with Excellent Sub Zero Temperature Properties

CLASSIFICATION : EN ISO 2560-A	AWS A/SFA 5.5
E 46 5 Mn1Ni B 12 H5	E 8016-G

KEY FEATURES :

- Basic type low hydrogen electrode
- Excellent impact properties at sub zero temperature
- Exhibits excellent mechanical properties in the as welded and post weld condition

WELDING POSITION :  **AC (70 OCV)/ DCEP**

TYPICAL APPLICATIONS :

- Welding of steels with high yield strength upto 450 MPa
- Welding and repairing high strength steels such as BS 4360-55 E/F

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	S	P
Typical	0.05	1.6	0.3	0.8	0.01	0.01
Specification	0.03-0.08	1.50-1.90	0.20-0.50	0.60-1.0	0.020 max.	0.02 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact At -51°C, J
Typical	As Welded	580	500	25	64
Specification		550 min	460 min	19 min	47 avg.

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 350	60-90	5	4	20
3.15 x 450	90-140	5	4	20
4.0 x 450	130-180	5	4	20
5.0 x 450	180-230	5	4	20