ador
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TENALLOY 16W

C-Mn STEEL (Low Hydrogen)

Stick Electrode for difficult to weld and unknown steels

CLASSIFICATION :	ISO 2560-A	AWS A/SFA 5.1	IS 814
	E 42 3 B 12 H5	E 7016	E B5426H_3X

KEY FEATURES :

- Low hydrogen lime coated
- Highly ductile welds provide resistance to cracks
- Excellent impact properties at subzero temperatures

WELDING POSITION :  **AC (90 OCV)/ DCEP**

TYPICAL APPLICATIONS :

- Highly suitable for difficult to weld steels e.g. High carbon, Alloy, High sulphur, Free machining, Cast, Cold rolled steels and Armor plates
- As a buffer layer before hardfacing
- High carbon steel to mild steel
- Steels of unknown composition
- Suitable for ASTM SA 414/414M Gr.C/D/E

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	0.9	0.4	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	520	450	28	164	68
Specification		490 min	400 min	22 min	150-200	50-80

Hardness, 3 Layer: 160 – 200 BHN **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	60-85	285	4	18
3.15 x 450	90-130	132	4	38
4.0 x 450	130-180	86	4	58
5.0 x 450	180-240	49	4	100