



TENALLOY 38R SPL

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 E7018-G

CLASSIFICATION:

ISO 2560-A
E 42 5 B 32 H5

KEY FEATURES:

- Heavy coated iron powder type
- Extremely high metallurgical purity
- C-1.2Mn-1Ni type weld deposit
- High impact at subzero temperatures

APPROVALS: CE

TYPICAL APPLICATIONS:

- A537 class 1 (modified)
- Si-Mn steel containing up to 1% Ni
- 15Mn Ni63 structural steel
- For heavy joints under restraint and subjected to dynamic loading
- Low temperature applications
- Structural steels, Boiler plates & Pipe steels
- Welding of fine grained structural steels with minimum yield strength of 420 MPA

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni
0.07	1.2	0.28	0.90


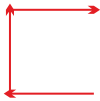
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J	
					-40°C	-50°C
Typical	As Welded	550	460	28	95	65
Specification		490 Min	400 Min	22 Min	80 min	50 min

Hardness (3 Layer): -200BHN 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	65-95		
3.15 x 450	90-140		
4.0 x 450	140-185		
5.0 x 450	180-250		

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

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