

TENALLOY 60

AWS A/SFA 5.5 E8018-G

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E 46 4 Z B 12 H5

KEY FEATURES:

- Basic coated electrode
- Ni-Mn type low alloy steel weld
- Excellent impact toughness down to -50°C
- Highly crack resistant welds
- Radiographic quality weld deposit
- All positional welding capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Pressure vessels, boilers
- Bridges, Heavy structures subject to dynamic loading and mechanical restraint
- Storage tanks, Pipes
- Joining steels containing 1% Ni
- Welding of ALDUR 45/60, ASTM SA-841/841M

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


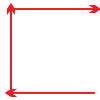
C	Mn	Si	Ni
0.08	1.5	0.3	0.75

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	605	520	26	54
Specification		550 min	460 min	19 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 60-90 100-140 140-180 190-250	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing