



## TENALLOY 60

LOW ALLOY STEEL (Low Temperature)



Welding Electrode for high tensile steel containing 1% Ni.

**CLASSIFICATION : EN ISO 2560-A**

**AWS A/SFA 5.5**

**APPROVALS :**

E 46 4 Z B 12 H5

E 8018-G

LRA/ABS

### 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

**WELDING POSITION :**



**AC (70 OCV)/DCEP**

### 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

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Ni</b>	<b>S</b>	<b>P</b>
Typical	0.08	1.5	0.3	0.6	0.02	0.02
Specification	0.05-0.10	1.40-1.85	0.20-0.48	0.45-0.80	0.03 max	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -50°C, J</b>
Typical	As Welded	605	520	26	54
Specification		550 min	460 min	19 min	40 avg.

Diffusible H2 Content: <5 ml/100 gm

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	240	4	21
3.15 x 450	100-140	115	4	44
4.0 x 450	140-180	86	4	58
5.0 x 450	190-250	49	4	100