

# TENALLOY 60D-3

AWS A/SFA 5.5 E8018-D3

LOW ALLOY STEEL (High Temperature)

## CLASSIFICATION:

EN ISO 3580-A  
E 46 5 Mn1Ni B 12 H5

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## KEY FEATURES:

- Medium-heavy coated electrode
- Mn-Mo type low alloy steel welds
- Exhibit good toughness at subzero temperatures
- All position capability
- Weld metal meets X-ray quality, ultrasonic and other code requirements
- Suitable for fully killed fine grained steels

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Welding of Mn-Mo type steels and equivalent grades
- Penstocks, Pressure vessels
- Welding low alloy high strength steels in 540 MPa UTS range
- Earth moving equipments

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


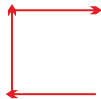
| C    | Mn  | Si  | Mo  |
|------|-----|-----|-----|
| 0.09 | 1.5 | 0.4 | 0.6 |

## MECHANICAL PROPERTIES OF ALL WELD METAL:

|               | Condition               | UTS, MPa | YS at 0.2% offset, MPa | EL%    | CVN Impact at -50°C, J |
|---------------|-------------------------|----------|------------------------|--------|------------------------|
| Typical       | PWHT:<br>620°C for 1 Hr | 605      | 510                    | 24     | 55                     |
| Specification |                         | 550 min  | 460-560                | 19 min | 47 min                 |

Diffusible H2 Content: <5 ml/100 gm

## PARAMETERS - PACKING DATA:

| Ø x L, mm  | Amperage, A |                                                                                                      |                                                                                       |
|------------|-------------|------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| 2.5 x 350  | 60-90       |  AC (70 OCV)/DCEP | All Positions, except vertical Downwards                                              |
| 3.15 x 350 | 90-140      |                                                                                                      |                                                                                       |
| 4.0 x 450  | 140-180     |                                                                                                      |                                                                                       |
| 5.0 x 450  | 180-250     |                                                                                                      |                                                                                       |
|            |             | <b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr.                                            |  |

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