



## TENALLOY 60D-3

LOW ALLOY STEEL (High Strength)



Electrode for welding high strength steel.

**CLASSIFICATION :** EN ISO 2560-A

AWS A/SFA 5.5

**APPROVALS :**

E 46 4 Z B 32 H5

E 8018-D3

IBR

### 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

**WELDING POSITION :**



AC (90 OCV)/DCEP

### 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

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

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

	C	Mn	Si	Ni	Mo	S	P
Typical	0.09	1.3	0.4	0.5	0.5	0.02	0.02
Specification	0.12 max	1.0 - 1.8	0.8 max	0.90 max	0.40-0.65	0.03 max	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -51°C, J
Typical	PWHT:	605	510	24	45
Specification	620°C for 1 Hr	550 min	460-560	19 min	30-80

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	60-90	208	4	24
3.15 x 450	90-140	108	4	46
4.0 x 450	140-180	73	4	68
5.0 x 450	180-250	47	4	106