

# TENALLOY 65 SPL

AWS A/SFA 5.5 E9018-G

LOW ALLOY STEEL (High Temperature)

## CLASSIFICATION:

EN ISO 18275-A  
E 55 4 Z B 32 H5

## KEY FEATURES:

- Basic type electrode
- Low hydrogen Ni-Mn-Mo type weld
- Good impact toughness at -40°C
- Medium penetration with base metal
- All position capability
- Radiographic quality weld
- Suitable for high strength steels with
- UTS of 620-730 Mpa

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Welding of high tensile steels
- Oil refineries, Penstocks, Submarines
- Boilers, Power house construction
- Earth moving equipments and other similar heavy fabrications
- Root pass in HY-100 steel

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

C	Mn	Si	Ni	Mo
0.05	1.3	0.3	1.3	0.4


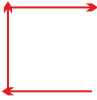
## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Typical	PWHT: 620°C for 2 hrs.	655	600	23	70
Specification		620 min	530 min	17 min	47 min

**Diffusible H2 Content:** <5 ml/100 gm

**Special Tests:** Hot Tensile Test at 370°C - 610 MPa

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 3.15 x 350 4.0 x 450 5.0 x 450	<b>Amperage, A</b> 100-140 140-180 190-250	 <b>AC (70 OCV)/DCEP</b> <b>REDRYING CONDITION:</b> 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 of 5 kgs each. Also available in vacuum packing