



TENALLOY 65 SPL

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E9018-G

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

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	60
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:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing