TENALLOY 65

LOW ALLOY STEEL (High Strength)

Ni-Mn-Mo type low alloy steel Welding Electrode.

CLASSIFICATION :	EN ISO 18275-A	AWS A/SFA 5.5
	E 55 5 Z B 32 H5	E 9018-G

KEY FEATURES :

- Basic coated iron powder electrode
- Ni-Mn-Mo type weld deposit
- Good impact toughness at -60°C
- All position capability
- Radiographic quality weld
- Suitable for medium-high tensile structural steels, heavy sections

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of high tensile steels, Pressure vessels, Boilers and heavy structures subject to dynamic loading and mechanical restraint
- Suitable for joining SA 662/662M Gr.A/B/C

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	Mo	S	P
Typical	0.06	1.4	0.3	1.4	0.3	0.02	0.02
Specification	0.09 max	1.20-1.70	0.20-0.45	1.10-1.60	0.25-0.40	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 -60°C, J
Typical	As Welded	655	580	23	54
Specification		620 min	530 min	17 min	35-70

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.
3.15 x 450	100-140	112	4	44
4.0 x 450	140-180	77	4	64
5.0 x 450	190-250	49	4	100