



TENALLOY 70

LOW ALLOY STEEL (High Strength)



Basic coated Electrode for welding high tensile structural steel.

CLASSIFICATION : EN ISO 18275-A

AWS A/SFA 5.5

E 55 2 Z B 32 H5

E 9018-G

KEY FEATURES :

- Basic coated electrode
- Ni-Mn type low alloy steel weld
- Optimum combination of strength and impact toughness
- Radiographic weld deposit
- Suitable for welding medium high tensile structural steels, heavy sections

WELDING POSITION :



AC (90 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of High tensile steels
- Pressure vessels, Boilers and heavy structures
- Joining ASTM SA 662/662M Gr.A/B/C

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	S	P
Typical	0.08	1.4	0.5	0.6	0.02	0.02
Specification	0.05-0.09	1.20-1.60	0.40-0.70	0.50-0.75	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 -30°C, J
Typical	As Welded	660	590	26	60
Specification		630-700	550-620	22-26	40-70

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.
2.5 x 350	60-90	232	4	22
3.15 x 450	100-140	111	4	45
4.0 x 450	140-180	76	4	65
5.0 x 450	190-250	49	4	100