



TENALLOY 70A

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-C1**

CLASSIFICATION:

EN ISO 2560-A
E 46 6 2Ni B 32 H5

IS 1395
E55 B-C1

KEY FEATURES:

- Basic coated electrode
- Ni-Mn type low alloy steel deposit
- Tough and crack free weld
- Excellent fracture toughness at subzero temperatures
- Radiographic quality weld
- All position capability

APPROVALS: ABS/RDSO/CE

TYPICAL APPLICATIONS:

- Welding of 2.5% Ni steel and similar low alloyed steel for impact at -60°C
- Suitable for ASTM SA 203/203M Gr.A/B
- Shipbuilding, Bridge structure
- In refineries, power plants e.g. Pressure vessels, Heat exchanger
- Cast steels, Low temperature steel pipes, Aluminium killed steels, Low Mn alloy steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


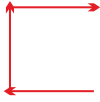
C	Mn	Si	Ni
0.04	0.8	0.3	2.3

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	610	515	26	70
Specification		550 min	460 min	19 min	47 min

Diffusible H2 Content: <5 ml/100 gm

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.
3.15 x 450	100-140	
4.0 x 450	140-180	
5.0 x 450	190-250	
		All Positions, except vertical Down 

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

EQUIVALENT:

GMAW	GTAW
Automig 80S-Ni2	Tigfil 80S-Ni2