



TENALLOY 70B

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-C2**

CLASSIFICATION:

EN ISO 2560-A
E 46 6 3Ni B 32 H5

IS 1395
E55B-C2

KEY FEATURES:

- Basic coated electrode
- Good impact toughness at subzero temperatures
- Ni-Mn type low alloy steel weld
- Radiographic weld deposit
- Positional welding capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 3.5% Ni steel and equivalent alloy demanding toughness down to -75°C
- Application in refineries, power plants e.g. Pressure vessels & heat exchangers
- Recommended for fine grained steel used at low temperature
- Petrochemical and Cryogenic industries
- Suitable for ASTM SA 203/203M Gr.B/D/E

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


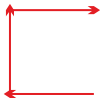
C	Mn	Si	Ni
0.05	0.8	0.3	3.2

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -75°C, J
Typical	PWHT: 600°C for 1 hr.	590	500	26	60
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.	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 5 kg each. Also available in vacuum packing