TENALLOY 70B

LOW ALLOY STEEL (Low Temperature)

Low alloy Welding Electrode for Cryogenic application

CLASSIFICATION : EN ISO 2560-A	AWS A/SFA 5.5	APPROVALS :
E 46 6 3Ni B 32 H5	E 8018-C2	IBR

KEY FEATURES :

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

WELDING POSITION : 

AC (90 OCV)/DCEP

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

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	S	P
Typical	0.05	0.8	0.3	3.4	0.015	0.02
Specification	0.12 max	1.25 max	0.80 max	3.0-3.75	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 -75°C, J
Typical	PWHT: 600°C for 1 hr.	590	500	26	52
Specification		550 min	460-550	19 min	40 avg.

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	122	4	41
4.0 x 450	140-180	80	4	63
5.0 x 450	190-250	50	4	100