

TENALLOY 70BL

AWS A/SFA 5.5 E7018-C2L

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E 38 9 3Ni 32 H5

KEY FEATURES:

- Basic type heavy coated electrode
- Low carbon low alloyed Ni-Mn weld deposit
- Weld deposit is highly ductile, tough
- Resist embrittlement at sub zero temperature
- Medium penetration with base metal
- Radiographic quality welds

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 3.0-3.75% Ni steel
- Fabrication of parts subjected to low temperature service
- Suitable for ASTM SA 203 Gr. E steel
- Application in Refinery, Pressure vessels & valves, Petrochemical
- Locomotive main frames, truck & side frames

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


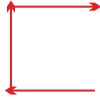
C	Mn	Si	Ni
0.04	1.25	0.25	3.2

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -75°C, J
Specification	PWHT: 600°C for 1 hr.	490 min	400 min	22 min	47 min

Diffusible H₂ Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 100-140 140-180 190-250	 AC (90 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing