



# TENALLOY 70BL

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E7018-C2L**

### CLASSIFICATION:

EN ISO 2560-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 %:


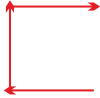
C	Mn	Si	Ni
0.04	1.25	0.25	3.2

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -100°C, J
Typical	PWHT: 600°C for 1 hr.	530	415	25	60
Specification		490 min	400 min	22 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	 <b>AC (70 OCV)/DCEP</b> All Positions, except vertical Down  <b>REDRYING CONDITION:</b> 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	

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