



TENALLOY 70BL

LOW ALLOY STEEL (Low Temperature)



Low alloy Welding Electrode for Cryogenic application.

CLASSIFICATION : EN ISO 2560-A AWS A/SFA 5.5 APPROVALS :

E 38 9 3Ni 32 H5

E 7018-C2L

IBR

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

WELDING POSITION :



AC (90 OCV)/DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	S	P
Specification	0.05 max	1.25 max	0.50 max	3.0-3.75	0.025 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -100°C, J
Specification	PWHT: 600°C for 1 Hr	490 min	390 min	22 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