



TENALLOY 70C

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-C3**

CLASSIFICATION:

EN ISO 2560-A
E 4641 Ni B32 H5

IS 1395
E55B - C3

KEY FEATURES:

- Basic coated electrode
- Typical Ni-Mo type welds
- Excellent fracture toughness at -40°C
- Superior crack resistance
- Radiographic quality welds
- All position capability

APPROVALS: ABS/CE

TYPICAL APPLICATIONS:

- Welding of high tensile steel, 1% Ni steel and equivalent steels
- Storage tanks for low temperature
- Off shore platforms, bridge
- Application in refineries, power plants e.g. pressure vessels and heat exchangers, machinery

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni
0.06	0.6	0.3	0.9


MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J	
					at -40°C	at -50°C
Typical	As Welded	600	530	26	90	60
Specification		550 min	460 min	19 min	47 min	-

Diffusible H2 Content: <5 ml/100 gm

Special Tests: HIC & SSCC (NACE)

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC (70 OCV)/DCEP	All Positions, except vertical Down
2.5 x 350	60-90		
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

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 80S-Ni1	Tigfil 80S-Ni1	Automig FC 81T1-Ni1	Automelt B71	Automelt ENi 1