



TENALLOY 70C

LOW ALLOY STEEL (Low Temperature)



Basic coated low alloy Welding Electrode for 1% Ni steel.

CLASSIFICATION : EN ISO 2560-A

AWS A/SFA 5.5

APPROVALS :

E 46 4 1Ni B 32 H5

E 8018-C3

ABS/IBR

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

WELDING POSITION :



AC (70 OCV)/DCEP

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

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	Mo	S	P
Typical	0.08	1.0	0.3	1.0	0.3	0.01	0.02
Specification	0.12 max	0.4 - 1.25	0.80 max	0.80-1.10	0.35 max	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 - 40°C, J
Typical	As Welded	600	530	26	78
Specification		550 Min	470-550	24 min	50-100

Hardness, 3 Layer: 200 BHN max

Diffusible H2 Content: <5 ml/100 gm

SPECIAL TEST : HIC & SSCC (NACE)

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	227	4	22
3.15 x 450	100-140	116	4	43
4.0 x 450	140-180	77	4	64
5.0 x 450	190-250	49	4	102