

TENALLOY 70CL

AWS A/SFA 5.5 E7018-C3L

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E 38 5 1Ni B 32 H5

KEY FEATURES:

- Basic coated low carbon electrode
- Typical Ni-Mo type welds
- Excellent fracture toughness at -50°C
- Superior crack resistance
- Radiographic quality welds
- All position capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of high tensile steels and fine grained steels like HY 80, HY 90, HY 100
- 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 %:


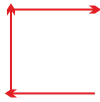
C	Mn	Si	Ni
0.05	1.0	0.3	1.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	530	440	26	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	 AC (70 OCV)/DCEP	All Positions, except vertical Downwards
3.15 x 350	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

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