



TENALLOY 75

LOW ALLOY STEEL (High Strength)



Ni-Mn alloyed welding Electrode for high tensile steel.

CLASSIFICATION : EN ISO 18275-A AWS A/SFA 5.5 APPROVALS :

E 55 4 Z B 32 H5 E 10018-M ABS/IBR

KEY FEATURES :

- Basic coated electrode
- Ni-Mn type weld deposit
- Moisture resistant coating
- Radiographic quality welds
- Suitable for positional welding

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of high tensile steels, heavy sections
- Earthmoving equipments and heavy structures
- Welding of USS T-1, NAXTRA 70, BH65 steels used for fabrication of penstocks

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	1.6	0.5	2.1	0.4	0.02	0.02
Specification	0.10 max	1.30-1.80	0.6 max	1.25-2.50	0.25 - 0.50	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 - 50°C, J
Typical	As Welded	765	705	23	57
Specification		690 min	610 - 690	20 min	30-70

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.
2.5 x 350	60-90	230	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	48	4	104