TENALLOY 75D-2

LOW ALLOY STEEL (High Strength)

Low alloyed Mn-Ni-Mo type Electrode for high tensile steel Welding.

CLASSIFICATION : EN ISO 18275-A	AWS A/SFA 5.5	APPROVALS :
E 55 4 Z B 32 H5	E 10018-D2	ABS

KEY FEATURES :

- Basic type electrode
- Mn-Ni-Mo type weld deposit
- High resistance to cracking and cold toughness at temperatures as low as -50°C
- Suitable preheat, interpass and PWHT is necessary to achieve desired properties
- Radiographic weld deposit
- Positional welding capability

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of fully killed fine grained high tensile steels used for fabrication of penstock, earthmoving equipments
- Heavy structures under restraint
- Used for materials with minimum tensile strength of 690 MPa

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	1.8	0.5	0.6	0.4	0.02	0.02
Specification	0.15 max	1.65-2.0	0.20-0.60	0.90 max	0.25-0.45	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	PWHT: 620°C for 1 Hr	725	640	19	56
Specification		690-790	600-700	16-24	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.
2.5 x 350	60-90	242	4	21
3.15 x 450	100-140	112	4	44
4.0 x 450	140-180	74	4	67
5.0 x 450	190-250	49	4	100