

# TENALLOY 75G

AWS A/SFA 5.5 E10018-G

LOW ALLOY STEEL (High Temperature)

## CLASSIFICATION:

EN ISO 18275-A  
E 55 5 Z B 32 H5

## KEY FEATURES:

- Basic type coating
- Optimum combination of strength and impact toughness at low temperature
- Ni-Cr-Mo type weld deposit
- Radiographic quality weld deposit
- All position capability

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Welding of grain refined steel and Ni steels
- Welding of DMR 249 Grade steels
- Storage tanks for liquefied gases like ammonia
- For heavy and highly restrained joints
- Distillers in coke oven batteries
- Petrochemical industries

## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



| C    | Mn  | Si  | Cr  | Ni  | Mo  |
|------|-----|-----|-----|-----|-----|
| 0.07 | 1.2 | 0.4 | 0.1 | 2.1 | 0.2 |

## 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 | 710      | 630                    | 22     | 60                     |
| Specification |           | 690 min  | 600 min                | 16 min | 47 min                 |

Diffusible H<sub>2</sub> Content: <5 ml/100 gm

## PARAMETERS - PACKING DATA:

|   |  |  |   |
|---|--|--|---|
| <b>Ø x L, mm</b><br>2.5 x 350<br>3.15 x 350<br>4.0 x 450<br>5.0 x 450 | <b>Amperage, A</b><br>70-110<br>90-140<br>120-200<br>180-250 |  <b>AC (70 OCV)/DCEP</b><br><br><b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr. | <b>All Positions</b><br> |
|---|--|--|---|

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing