



TENALLOY 75G

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E10018-G**

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 H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

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

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