



TENALLOY 75G

LOW ALLOY STEEL (High Strength)



Welding Electrode depositing high strength Ni-Cr-Mo type weld metal.

CLASSIFICATION : EN ISO 18275-A

AWS A/SFA 5.5

E 55 5 Z B 32 H5

E 10018-G

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

WELDING POSITION :



AC (70 OCV)/DCEP

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

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	Cr	Ni
Typical	0.07	1.2	0.4	0.1	2.1
Specification	0.10 max	0.90-1.50	0.30-0.60	0.25 max	1.80-2.20
	Mo	V	S	P	
Typical	0.2	0.01	0.005	0.01	
Specification	0.30 max	0.02 max	0.010 max	0.015 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	710	630	22	56
Specification		760 min	670 min	15 min	50-60

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 350	70-110	2	8	16
3.15 x 450	90-140	2	8	16
4.0 x 450	150-200	2	8	16
5.0 x 450	180-250	2	8	16