



TENALLOY 80

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E11018-M**

CLASSIFICATION:

EN ISO 18275-A
E 69 4 Z B 32 H5

KEY FEATURES:

- Basic type coating
- Ni-Mn-Mo-Cr-V type electrode
- Excellent crack resistant
- Excellent toughness at subzero temperature
- Radiographic quality weld metal

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of high tensile steels like USS T-1, Fine grained steels like HY 80, HY 90, HY 100, NAXTRA 70
- Penstocks, Earthmoving equipments
- Heavy structures under restraint
- Suitable for ASTM SA 225/225M Gr.C/ D, SA 533/533M Gr.B/C/D, SA 543/ 543M Gr.B/

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


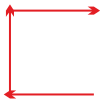
C	Mn	Si	Ni	Cr	Mo
0.06	1.6	0.35	1.75	0.2	0.4

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	820	730	22	60
Specification		760 min	680 - 760	20 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

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