

# TENALLOY 80HH SPL

AWS A/SFA 5.5 E11018-M

LOW ALLOY STEEL (High Temperature)

## CLASSIFICATION:

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

## KEY FEATURES:

- Extra low hydrogen electrode
- Low alloy high tensile steel electrode
- Good impact toughness at -50°C
- All position capability
- Radiographic quality weld
- Suitable for welding fully killed fine grained steels

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Penstocks, Earth moving equipments & other heavy steel fabrications made from high tensile steels
- Welding USS T-1 steel, Heat treated fine grained steels, NAXTRA 70, Hy80
- Suitable for ASTM SA 225/225M Gr.C/D, SA 533/533M Gr.B/C/D Class 2 and 3, SA 543/543M Gr.B/C Class 1 and 2, SA 612/612M, SA 738/738M Gr.A/B/C

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


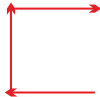
C	Mn	Si	Ni	Cr	Mo	V
0.08	1.6	0.5	1.8	0.3	0.4	0.4

## 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	715	22	50
Specification		760 min	680 - 760	20 min	47 min

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

## PARAMETERS - PACKING DATA:

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

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