



## TENCALLOY 80HH SPL

LOW ALLOY STEEL (High Strength)



Extra low hydrogen low alloy Welding Electrode for high strength with subzero application.

**CLASSIFICATION :** EN ISO 18275-A

AWS A/SFA 5.5

**APPROVALS :**

E 69 4 Z B 32 H5

E 11018-M

IBR

### 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

**WELDING POSITION :**



AC (90 OCV)/DCEP

### 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

**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	Ni	Cr
Typical	0.08	1.6	0.5	1.8	0.3
Specification	0.10 max	1.30 - 1.80	0.6 max	1.25-2.50	0.40 max
	Mo	V	S	P	
Typical	0.4	0.02	0.005	0.007	
Specification	0.25 - 0.50	0.05 max	0.03 max	0.03 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	820	715	22	44
Specification		770-870	690-760	20-24	30-70

Diffusible H2 Content: <3 ml/100 gm

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	215	4	23
3.15 x 450	90-140	113	4	44
4.0 x 450	140-180	78	4	63
5.0 x 450	180-250	51	4	96