

TENALLOY 90D3

AWS A/SFA 5.5 E9018-D3

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E 50 3 Z B 32 H5

KEY FEATURES:

- Basic coated electrode
- Typical Mn-Mo type weld deposit
- Excellent fracture toughness down to -50°C
- Suitable for welding fully killed fine grained steel
- Suitable preheat, interpass and PWHT is required depending on base metal composition
- All position capability
- Radiographic quality welds

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of low alloy high tensile steels of typical UTS 650 Mpa
- Welding of Q&T fine grained steels
- Penstocks, Earth moving equipments
- Suitable for low alloy structural steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

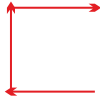
C	Mn	Si
0.09	1.65	0.80

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	PWHT: 620°C for 1 hr.	620 min	530 min	17 min	47 min
Specification					

Diffusible H₂ Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 100-140 140-180 190-250	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing