



## TENALLOY HH SPL

C-Mn STEEL (Low Hydrogen)



Welding Electrode for joining High Tensile Steels

### CLASSIFICATION : ISO 2560-A

E 42 5 B 32 H5

### AWS A/SFA 5.1

E 7018-1

### IS 814

E B5629H<sub>3</sub>JX

### APPROVALS :

MEETS NACE Requirements,  
ONGC/EIL, Spec GS8  
Annexure 1A

### KEY FEATURES :

- Extra low hydrogen iron powder type
- Weld metal resistant to cold and hot cracking and tri-axial stressing
- Medium Penetration
- Excellent toughness down to -46°C
- All position capability

### WELDING POSITION :



AC (90 OCV)/ DCEP

### TYPICAL APPLICATIONS :

- Carbon and low alloy steel fabrication where severe service condition exist
- Suitable for medium high tensile steels, heavy sections and restrained joints in high tensile steel
- Joining steels of ASTM 106 Gr.B (NACE quality), SA 414/414M Gr.D/E/F/G, SA 515/515M Gr.60/65, SA 516/516M Gr.60/65

**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	S	P
Typical	0.06	1.1	0.3	0.01	0.01
Specification	0.15 max	1.6 max	0.75 max	0.035 max	0.035 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact , J	
					-30°C	-46°C
Typical	As Welded	550	465	26	70	52
Specification		490 min	400 min	22 min	50-100	30-60

**Hardness, 3 Layer: 200 BHN max**

**Diffusible H2 Content: <3 ml/100 gm**

**SPECIAL TESTS : HIC, SSCC, Hot Tensile Test at 200°C**

### 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	281	4	18
3.15 x 450	90-140	132	4	38
4.0 x 450	140-180	85	4	58
5.0 x 450	180-240	55	4	89