



TENALLOY R

C-Mn STEEL (Low Hydrogen)



Coated Welding Electrode with Excellent Subzero Temperature Properties

CLASSIFICATION : ISO 2560-A

IS 814

E 42 5 B 32 H5

E B5629H₃JX

KEY FEATURES :

- Basic type iron powder electrode
- Deposition efficiency approx 110%
- Exhibit excellent impact at subzero temperatures
- All position capability

WELDING POSITION :



AC (90 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Ammonia storage tanks
- Horton spheres, Pressure vessels
- Si-Mn steels
- Steels containing Ni upto 1%
- For mild steel and heavy joints at sub-zero temperatures
- Joining ASTM SA 515/515M Gr.60/65, SA 516/516M Gr.60/65 steels

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.06	1.2	0.3	0.02	0.02
Specification	0.04-0.09	0.8-1.6	0.20-0.45	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	550	480	27	50
Specification		490	400	22	40-70

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	235	4	21
3.15 x 450	90-140	120	4	41
4.0 x 450	140-180	75	4	67
5.0 x 450	180-250	49	4	102