



# TENALLOY 16

**C-Mn STEEL (Low Hydrogen)**



Special Welding Electrode for Buffer Layer and Repair Welding

<b>CLASSIFICATION : EN ISO 2560-A</b>	<b>AWS A/SFA 5.1</b>	<b>IS 814</b>	<b>APPROVALS :</b>
E 42 3 B 12 H5	E 7016	E B5426H <sub>3</sub> X	ABS/BV/DNV/IRS/LRA/IBR

### KEY FEATURES :

- Basic coated low hydrogen electrode
- Ductile weld metal provide superior crack resistance
- All position capability
- Excellent impact properties down to -30°C
- Radiographic weld deposit

<b>WELDING POSITION :</b>			<b>AC (70 OCV)/ DCEP</b>
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### TYPICAL APPLICATIONS :

- Buffer layer before hardfacing
- Joining cast iron to mild steel
- Repair of cast iron
- Butt welding of rail ends
- Fixing of rails to mild steel girders

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	1.2	0.5	0.02	0.02
Specification	0.04-0.10	0.80-1.50	0.25-0.65	0.03 max.	0.03 max.

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact , J</b>	
					<b>27°C</b>	<b>-30°C</b>
Typical	As Welded	560	475	27	160	63
Specification		510-620	440-550	24 min.	140-200	50-80

**Hardness, 3 Layers: 200 BHN max.**

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

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-80	287	4	17
3.15 x 450	90-120	133	4	37
4.0 x 450	130-170	86	4	58
5.0 x 450	180-230	54	4	91

