



TENALLOY 16G

C-Mn STEEL (Low Hydrogen)



Welding Electrode with Excellent Low Temperature Properties

CLASSIFICATION : EN ISO 2560-A AWS A/SFA 5.5

E 38 3 1Ni B 12 H5 E 7016-G

KEY FEATURES :

- Basic type coating
- All position capability
- Radiographic quality weld
- Excellent mechanical properties at sub-zero temperatures

WELDING POSITION :



AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Joining ASTM SA 515 Gr.55, SA 516, Gr.55 pressure vessel steels subjected to intermediate & lower temperature applications
- Suitable for medium tensile and low alloy steels

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	S	P
Typical	0.07	1.0	0.5	0.8	0.02	0.02
Specification	0.10 max	0.8-1.20	0.75 max	0.5-1.0	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 -30°C , J
Typical	As Welded	540	450	28	58
Specification		500 min	400 min	26 min	35 min

Hardness, 3 Layers: 200 BHN max.

Diffusible H2 Content: <5 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	192	4	26
3.15 x 450	90-140	128	4	39
4.0 x 450	130-180	81	4	62
5.0 x 450	180-230	52	4	96

