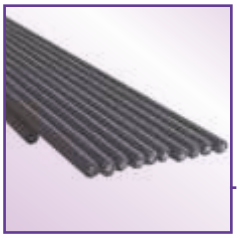

TENALLOY 38R SPL

C-Mn STEEL (Low Hydrogen)

Stick Welding Electrode with Excellent Mechanical & Impact Properties at Low Temperatures

CLASSIFICATION :	DIN 8529	AWS A/SFA 5.5
	E SY 42761 Ni B75	E 7018-G

KEY FEATURES :

- Heavy coated iron powder type
- Extremely high metallurgical purity
- C-1.2Mn-1Ni type weld deposit
- High impact at subzero temperatures

WELDING POSITION :

DCEP

TYPICAL APPLICATIONS :

- A537 class 1 (modified)
- Si-Mn steel containing up to 1% Ni
- 15Mn Ni63 structural steel
- For heavy joints under restraint and subjected to dynamic loading
- Low temperature applications
- Structural steels, Boiler plates & Pipe steels
- Welding of fine grained structural steels with minimum yield strength of 420 MPA

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni
Typical	0.07	1.2	0.28	0.08	0.8
Specification	0.05-0.10	1.0-1.50	0.15-0.45	0.1 max	0.70 - 1.0
	Mo	**Cu**	**S**	**P**	
Typical	0.04	0.08	0.01	0.01	
Specification	0.06 max	0.10 max	0.015 max	0.015 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J		
					-20°C	-40°C	-50°C
Typical	As Welded	550	460	28	142	97	67
Specification		500 min	425 min	25 min	120 min	80 min	50 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
2.5 x 350	65-95	5	4	20
3.15 x 450	90-140	5	4	20
4.0 x 450	140-185	5	4	20
5.0 x 450	180-250	5	4	20