



# TENALLOY R

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



Coated Welding Electrode with Excellent Subzero Temperature Properties

**CLASSIFICATION : AWS A/SFA 5.1**

**IS 814**

E 7018-G

E B5629H<sub>3</sub>JX

## 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 % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.06	1.2	0.3	0.02	0.02
Specification	0.04-0.09	0.80-1.60	0.20-0.45	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 At -50°C , J</b>
Typical	As Welded	550	480	27	50
Specification		510-600	425-540	24-30	40-70

## 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	60-90	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