



Tenalloy 16

C-Mn STEEL (Low Hydrogen)



Special Welding Electrode for Buffer Layer and Repair Welding

CLASSIFICATION : EN ISO 2560-A AWS A/SFA 5.1 IS 814 APPROVALS :
 E 42 3 B 12 H5 E 7016 E B5426H₃X 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

WELDING POSITION :



AC (70 OCV)/ DCEP

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 : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
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 :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact , J	
					27°C	-30°C
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 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	60-80	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