



TENALLOY 70D

LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.5 **E8018-C4**

CLASSIFICATION:

EN ISO 2560-A
E 46 5 2Ni B42 H5

KEY FEATURES:

- Basic coated electrode
- Smooth, stable arc, low spatter
- Easy slag removal
- Excellent fracture toughness at -50°C
- Tough and crack resistant weld
- Radiographic quality welds
- All position capability

TYPICAL APPLICATIONS:

- Welding of high tensile steel having 1 to 2% Ni and equivalent steels
- Application in refineries, power plants
- Off shore platforms, bridges
- Storage tanks, Pipes
- Pressure vessels, Boilers

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


| C | Mn | Si | Ni |
|------|------|-----|-----|
| 0.07 | 0.65 | 0.3 | 1.6 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact at -50°C, J |
|---------------|-----------|----------|------------------------|--------|------------------------|
| Typical | As Welded | 600 | 500 | 21 | 60 |
| Specification | | 550 min | 460 min | 19 min | 47 min |

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

| Ø x L, mm | Amperage, A |  AC (70 OCV)/DCEP | All Positions, except vertical Down |
|------------|-------------|--|-------------------------------------|
| 2.5 x 350 | 60-90 | | |
| 3.15 x 450 | 100-140 | | |
| 4.0 x 350 | 140-180 | | |
| 5.0 x 450 | 190-250 | | |

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

Available in Standard carton packing of 20 kg box containing 4 cartons 5 kg each. Also available in vacuum packing