



TENALLOY 60D-3

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-D3**

CLASSIFICATION:

EN ISO 2560-A
E 46 5 Mn1Ni B 12 H5

KEY FEATURES:

- Medium-heavy coated electrode
- Mn-Mo type low alloy steel welds
- Exhibit good toughness at subzero temperatures
- All position capability
- Weld metal meets X-ray quality, ultrasonic and other code requirements
- Suitable for fully killed fine grained steels

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of Mn-Mo type steels and equivalent grades
- Penstocks, Pressure vessels
- Welding low alloy high strength steels in 540 MPa UTS range
- Earth moving equipments

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Mo
0.09	1.5	0.4	0.6

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	PWHT: 620°C for 1 Hr	605	510	24	55
Specification		550 min	460-560	19 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV)/DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	90-140	
4.0 x 450	140-180	
5.0 x 450	190-250	

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