



# 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 |  |  |
|------------|-------------|--|--|
| 2.5 x 350  | 60-90       |  <b>AC (70 OCV)/DCEP</b><br><b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr. | All Positions, except vertical Down<br> |
| 3.15 x 450 | 100-140     |  |  |
| 4.0 x 350  | 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