



TENALLOY 16E SPL

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E8016-G

CLASSIFICATION:

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

KEY FEATURES:

- Basic type low hydrogen electrode
- Excellent impact properties at sub zero temperature
- Exhibits excellent mechanical properties in the as welded and post weld condition

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of steels with high yield strength upto 450 Mpa
- Welding and repairing high strength steels such as BS 4360-55 E/F

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


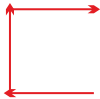
C	Mn	Si	Ni
0.06	1.6	0.3	0.8

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	580	500	23	65
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	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	100-140		
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