



# TENALLOY 60

LOW ALLOY STEEL (High Temperature)

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

### CLASSIFICATION:

EN ISO 2560-A  
E 46 4 Z B 12 H5

### KEY FEATURES:

- Basic coated electrode
- Ni-Mn type low alloy steel weld
- Excellent impact toughness down to -50°C
- Highly crack resistant welds
- Radiographic quality weld deposit
- All positional welding capability

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Pressure vessels, boilers
- Bridges, Heavy structures subject to dynamic loading and mechanical restraint
- Storage tanks, Pipes
- Joining steels containing 1% Ni
- Welding of ALDUR 45/60, ASTM SA-841/841M

### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


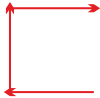
C	Mn	Si	Ni
0.08	1.5	0.3	0.75

### 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	605	520	26	54
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>  <b>REDRYING CONDITION:</b> 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