



# TENALLOY 60N

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E8018-G

### KEY FEATURES:

- Suitable for normalizing requirements
- Retains toughness down to -30°C after normalizing heat treatment
- Highly crack resistant welds
- Radiographic quality weld deposit
- All positional welding capability

### TYPICAL APPLICATIONS:

- Pressure vessels, Boilers, Dish-ends
- 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 %:


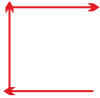
| C    | Mn  | Si   | Ni  |
|------|-----|------|-----|
| 0.07 | 1.8 | 0.45 | 0.6 |

### MECHANICAL PROPERTIES OF ALL WELD METAL:

|         | Condition        | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact at -30°C, J |
|---------|------------------|----------|------------------------|-----|------------------------|
| Typical | As Welded        | 645      | 580                    | 24  | 80                     |
|         | Normalizing + SR | 535      | 405                    | 26  | 45                     |

Diffusible H2 Content: <5 ml/100 gm

### PARAMETERS - PACKING DATA:

| Ø x L, mm  | Amperage, A |  |  |
|------------|-------------|--|--|
| 2.5 x 350  | 65-100      |  AC (70 OCV)/DCEP | All Positions, except vertical Down<br> |
| 3.15 x 450 | 100-140     |  |  |
| 4.0 x 450  | 140-180     |  |  |
|            |             | <b>REDRYING CONDITION:</b><br>250-300°C for minimum 1 hr.  |  |

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