



# TENALLOY 65

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E9018-G**

### CLASSIFICATION:

EN ISO 18275-A  
E 55 5 Z B 32 H5

### KEY FEATURES:

- Basic coated iron powder electrode
- Ni-Mn-Mo type weld deposit
- Good impact toughness at -60°C
- All position capability
- Radiographic quality weld
- Suitable for medium-high tensile structural steels, heavy sections

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of low alloy high tensile steels of typical UTS 650 Mpa
- Penstocks, Earth moving equipments and other similar fabrications

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


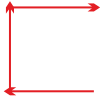
C	Mn	Si	Ni	Mo
0.06	1.7	0.3	1.5	0.4

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -60°C, J
Typical	As Welded	655	580	23	60
Specification		620 min	530 min	17 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 of 5 kg each. Also available in vacuum packing