



# TENALLOY 70

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E9018-G

### CLASSIFICATION:

EN ISO 18275-A  
E 55 2 Z B 32 H5

### KEY FEATURES:

- Basic coated electrode
- Ni-Mn type low alloy steel weld
- Optimum combination of strength and impact toughness
- Radiographic weld deposit
- Suitable for welding medium high tensile structural steels, heavy sections

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of High tensile steels
- Pressure vessels, Boilers and heavy structures
- Joining ASTM SA 662/662M Gr.A/B/C

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


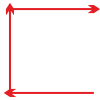
C	Mn	Si	Ni
0.05	1.4	0.6	0.6

### 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	660	590	26	60
Specification		630-700	550-620	22-26	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 All Positions, except vertical Down  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.
3.15 x 450	100-140	
4.0 x 450	140-180	
5.0 x 450	180-250	

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