



TENALLOY 70D1

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E9018-D1**

CLASSIFICATION:

EN ISO 2560-A
E 50 3 Z B 32 H5

KEY FEATURES:

- Basic coated electrode
- Typical Mn-Mo type weld deposit
- Excellent fracture toughness down to -50°C
- Suitable for welding fully killed fine grained steel
- Suitable preheat, interpass and PWHT is required depending on base metal composition
- All position capability
- Radiographic quality welds

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 %:


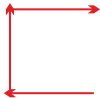
C	Mn	Si	Mo
0.07	1.6	0.6	0.35

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	PWHT: 620°C for 1 hr.	690	600	20	55
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		
3.15 x 350	100-140	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
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