



TENALLOY 75

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E10018-M**

CLASSIFICATION:

EN ISO 18275-A
E 55 4 Z B 32 H5

KEY FEATURES:

- Basic coated electrode
- Ni-Mn type weld deposit
- Moisture resistant coating
- Radiographic quality welds
- Suitable for positional welding

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of high tensile steels, heavy sections
- Earthmoving equipments and heavy structures
- Welding of USS T-1, NAXTRA 70, BH65 steels used for fabrication of penstocks

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Mo
0.06	1.5	0.5	1.9	0.27

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	765	655	23	60
Specification		690 min	610 - 690	20 min	47 min

Diffusible H2 Content: <5 ml/100 gm

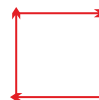
PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
2.5 x 350	60-90
3.15 x 450	100-140
4.0 x 450	140-180
5.0 x 450	190-250



AC (70 OCV)/DCEP

All Positions, except vertical Down



REDRYING CONDITION:
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