



TENALLOY 75D-2

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E10018-D2**

CLASSIFICATION:

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

IS 1395
E68B-D2

KEY FEATURES:

- Basic type electrode
- Mn-Ni-Mo type weld deposit
- High resistance to cracking and cold toughness at temperatures as low as -50°C
- Suitable preheat, interpass and PWHT is necessary to achieve desired properties
- Radiographic weld deposit
- Positional welding capability

APPROVALS: ABS/CE

TYPICAL APPLICATIONS:

- Welding of fully killed fine grained high tensile steels used for fabrication of penstock, earthmoving equipments
- Heavy structures under restraint
- Used for materials with minimum tensile strength of 690 Mpa

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


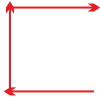
C	Mn	Si	Mo	Ni
0.09	1.8	0.5	0.3	0.6

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	725	640	19	55
Specification		690 min	600 min	16 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	 AC (70 OCV)/DCEP REDRYING CONDITION: 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	
		All Positions, except vertical Down 

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