



TENALLOY 80HH SPL

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E11018-M**

CLASSIFICATION:

EN ISO 18275-A
E 69 4 Z B 32 H5

KEY FEATURES:

- Extra low hydrogen electrode
- Low alloy high tensile steel electrode
- Good impact toughness at -50°C
- All position capability
- Radiographic quality weld
- Suitable for welding fully killed fine grained steels

APPROVALS: CE

TYPICAL APPLICATIONS:

- Penstocks, Earth moving equipments & other heavy steel fabrications made from high tensile steels
- Welding USS T-1 steel, Heat treated fine grained steels, NAXTRA 70, Hy80
- Suitable for ASTM SA 225/225M Gr.C/D, SA 533/533M Gr.B/C/D Class 2 and 3, SA 543/543M Gr.B/C Class 1 and 2, SA 612/612M, SA 738/738M Gr.A/B/C

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


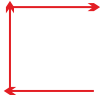
C	Mn	Si	Ni	Cr	Mo
0.08	1.6	0.5	1.8	03	0.4

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	820	715	22	50
Specification		760 min	680 - 760	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	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	90-140		
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