



TENALLOY 80P2

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8045-P2 H4R**

CLASSIFICATION:

EN ISO 2560-A
E 46 5 1Ni B 4 5

KEY FEATURES:

- Medium-heavy coated electrode
- Mn-Mo type low alloy steel welds
- Exhibit good toughness at subzero temperatures
- Exhibit excellent performance in vertical down
- All position capability
- Weld metal meets X-ray quality, ultrasonic and other code requirements
- Suitable for fully killed fine grained steels

APPROVALS: CE

TYPICAL APPLICATIONS:

- Basic type coating
- Easy to use with controllable slag system
- Deposit is extremely crack resistant
- High toughness and a very low hydrogen content
- Suitable for filler and cover pass welding in pipeline construction

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Mo
0.06	1.3	0.6	0.3

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	600	500	23	60
Specification		550 min	460 min	19 min	27 min

Diffusible H2 Content: <4 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV)/DCEP All Positions, specifically in vertical down REDRYING CONDITION: 250-300°C for minimum 1 hr. 
3.15 x 350	90-140	
4.0 x 350	140-180	

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