



TENALLOY Z PLUS

C-Mn STEEL (Low Hydrogen)

AWS A/SFA 5.1 E7018-1 H4R

CLASSIFICATION:

EN ISO 2560-A
E 42 4 B 32 H5

IS 814
EB5629H₃JX

KEY FEATURES:

- Basic coated iron powder type
- Suitable for pipe welding in 5G, 6G & 6GR positions
- Excellent toughness down to -50°C
- Radiographic weld deposit
- All position capability

APPROVALS: ABS/BV/DNV/IRS/LRA/NPCIL/BHEL/NTPC/BIS/CE

TYPICAL APPLICATIONS:

- Storage tanks, pipes, boilers
- Bridges & heavy structures subject to dynamic loading
- Joining ASTM SA 414/414M Gr.C/D, SA 516/516M Gr.55/60, IS 2002, IS 2062 steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.5	0.3

MECHANICAL PROPERTIES OF ALL WELD METAL:


	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -46°C, J
Typical	As Welded	560	480	27	60
Specification		490 min	400 min	22 min	50 min

Hardness (3 Layer): 200 BHN max

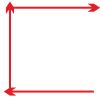
Diffusible H2 Content: <5 ml/100 gm

Special Test: HIC & SSCC (NACE)

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 350	90-140	
3.15 x 450	90-140	
4.0 x 450	140-180	
5.0 x 450	180-240	

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

EQUIVALENT:

GTAW	FCAW	SAW	
		Flux	Wire
Tigfil 70S-2 SPL	Automig FC 71T-5	Automelt B20 Plus	Automelt EH12K
Tigfil 70S-3	-	Automelt B41	Automelt EH10K
Tigfil 70S-6	-	Automelt B41	Automelt EH14