TENALLOY 16E (SPL)

CLASSIFICATIONS

AWS A/SFA 5.5 E8016-G

IDENTIFICATION: Name Printed

CHARACTERISTICS

All position low hydrogen electrode with excellent sub-zero impact value. The weld metal has good mechanical properties both in the as welded and stress relieved condition.

TYPICAL APPLICATIONS

Developed for welding high yield steels (450 N / mm^2). Used mainly for welding and repairing of high strength steels such as BS 4360 55 E/F. Exhibits excellent post weld mechanical properties.

CURRENT CONDITIONS: AC (OCV70) / DC (+)

5.0	4.0	3.2	2.5
180-230	130-180	90-140	60-90

WELDING POSITIONS

F, H, V -up,OH

REDRYING CONDITIONS

300^{0}C for 1 hour

(Optionally also available in vacuum-packed condition.)

WELD METAL CHEMISTRY, (%)

C - 0.03 - 0.08	S - 0.020 max.	Cr - 0.05 max	Diffusible H_2
Mn - 1.50 - 1.90	P - 0.025 max.	Ni - 0.60-1.00	Content, <5 ml/100gm
Si - 0.20 - 0.50	Mo - 0.04 max.	V - 0.02 max	of weld metal
Cu - 0.05 max			

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Wt. per carton, kg	5	5	5	5
Cartons / box	4	4	4	4
Net wt per box, kg	20	20	20	20

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J
	MPa	MPa	(L=4Xd)	-51^{0}C
As-welded	550 min.	460 min.	20min.	47 (avg.)