

TENALLOY S PLUS-H4R (R2U)

CLASSIFICATIONS

AWS A/SFA 5.1 E7018-1H4R

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. Weld metal exhibits excellent toughness upto minus 60°C. It gives excellent arc stability, arc smoothness and very easy slag removal. It has exceptional all - positional operating characteristics giving X-ray quality welds even for pipe welding in 5G, 6G positions.

TYPICAL APPLICATIONS

Welding for storage tanks, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM SA-414/SA-414M Gr. C&D (P. No. 1) Gr.55, Gr 60 steels of SA -516/516M (P. No. 1) IS 2002, 2062 etc. Tight control on impurities and alloying elements ensure excellent impact in all positions.

CURRENT CONDITIONS : AC (70V), DC (+)

5.0	4.0	3.2	2.5
180-280	140-180	90-140	60-90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

NONE.

Ready - to - use (R2U) packing and coating design ensures electrodes can be used directly after opening the packet, for upto 8 hours after opening the packet.

WELD METAL CHEMISTRY, (%)

C - 0.03 - 0.07	S - 0.015 max	Diffusible H ₂
Mn - 1.0 - 1.50	P - 0.015 max	Content, <4 ml/100gm of weld metal
Si - 0.20 - 0.45		

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Wt. per vacuum pack, kg	2	2	2	2
Vacuum pack / box	8	8	8	8
Net wt per box, kg	16	16	16	16

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS	YS	%Elong.	CVN Impacts, J				HARDNESS BHN
	MPa	MPa		-30°C	-46°C	-51°C	-60°C	
As-welded	520-640	450-540	25 min	80-120	60-100	40-70	30-60	180 max
PWHT : 620°C/4 hrs.	500-600	430-500	25 min	80-120	60-100	40-70	30-60	180 max



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