

TENALLOY

CLASSIFICATIONS

AWS A/SFA 5.1 E7018-1

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low hydrogen, iron-power type electrode. Weld metal gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality even for pipe welding in 5G & 6G position and exhibits excellent toughness upto minus 50°C

TYPICAL APPLICATIONS

Suitable for welding of ASTM SA-414M Gr.C&D(P.No.1) Gr.55, Gr.60 steels of SA-516/516M (P.No.1, IS:2002, IS:2062 etc,. This types of weld metal mainly used for manufacturing the storage tanks, pipes pressure vessels, boilers, bridges and heavy structures to dynamic loading and mechanical restraint.

WELD METAL CHEMISTRY, (%)

C - 0.04-0.09	Mn - 0.80-1.60
S - 0.03 max	P - 0.03 max
	Si - 0.20-0.45

CURRENT CONDITIONS: AC / DC (+)

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

WELDING POSITIONS:

F, H, V-down, V-up, OH

REDRYING CONDITIONS

300°C for 1 hr

PACKING DATA

Dia,mm	5.0	4.0	3.2
Length,mm	450	450	450
Wt. per carton, kgs	5	5	5
Wt. per box, kgs	20	20	20

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	RA %	CVN Impacts, J -46°C	Hardness (BHN)
As-welded	520-640	450-540	24 min	45 min	30-50 min	200 max



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ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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