

# TENALLOY 16

## CLASSIFICATIONS

**AWS A/SFA 5.1** E7016

**IS 814** E B5426H<sub>3</sub>X

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A low-hydrogen electrode used as buffer layer for hardfacing and for joining Cast iron (CI) to mild steel. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

## TYPICAL APPLICATIONS

Welding of CI to Mild steel; Butt welding of rail ends; For fixing of rails to mild steel girders; Repair of CI (Preheating necessary).

## APPROVALS

**ABS** Gr. -3YH5

**BV** Gr. -3YH5

**DNV** Gr. -3YH10

**IRS** Gr. -3YHHH, HHH

**LRA** 3YmH5, NA

**IBR** E 7016

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

5.0 4.0 3.2 2.5

180-230 130-170 90-120 60-80

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition.)

### WELD METAL CHEMISTRY, (%)

C - 0.04 - 0.10	S - 0.030 max	Diffusible H <sub>2</sub>
Mn - 0.80 - 1.50	P - 0.030 max	Content, <5 ml/100gm of weld metal
Si - 0.25 - 0.65		

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J	
	MPa	MPa	(L=4Xd)	27°C	-30°C
As-welded	510-620	440-550	24 min	140-200	50-80

### PACKING DATA

	5.0	4.0	3.2	2.5
Dia., mm	450	450	450	350
Length, mm	54	86	133	287
Pcs per carton, Nos	4	4	4	4
Cartons / box	216	344	532	1148
Pcs per box, Nos	91	58	37	17
Approx. Wt. of 1000 pcs,kg				



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