TENALLOY 55

CLASSIFICATIONS

AWS A/SFA 5.5 E8018-G

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. Weld metal exhibits excellent toughness upto minus 50°C. Weld metal contains 1.0% Ni and 0.5%Cu and has excellent atmospheric corrosion resistance. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

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

5.0	4.0	3.2	2.5
190-250	140-180	100-140	60-90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in v condition.)

TYPICAL APPLICATIONS

Welding of Storage tanks, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechani Suitable for joining steels containing 1% Ni and ~ 0.5% Cu.

WELD METAL CHEMISTRY, (%)

C - 0.095 max.	S - 0.030 max.	Ni - 0.70-1.25	Diffusible H_2
Mn - 1.0 - 1.65	P - 0.030 max.		Content < 5 ml/ 100gm
Si - 0.25 - 0.65			of weld metal

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4Xd)	CVN Impacts, J -50° C
As-welded	560-680	470-590	24 min.	50 (avg.)

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	49	76	113	227
Cartons / box	4	4	4	4
Pcs per box, Nos	196	304	452	908
Approx. Wt. of 1000 pcs,kg	100	65	44	22