TENALLOY 60

CLASSIFICATIONS

AWS A/SFA 5.5 E8018-G

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode for welding of high tensile, fine grained steels. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

APPROVALS

ABS E 8018-G
LRA E 8018-G

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 vacuum-packed condition.)

TYPICAL APPLICATIONS

Welding of pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels containing 1% Ni. Welding of steels BH 39/47/W27/ W30, ALDUR 45/60; SA-841/841M

WELD METAL CHEMISTRY, (%)		
C - 0.05 - 0.10	S - 0.030 max.	Diffusible H_2
Mn - 1.40 - 1.85	P - 0.030 max.	Content < 5 ml/100gm
Si - 0.20 - 0.48	Ni - 0.45-0.80	of weld metal

MECHANICAL PROPERTIES- ALL-WELD					
Condition	**UTS**	**YS**	**% Elong.**	**CVN Impacts, J**	
	MPa	MPa	(L=4xd)	27°C	-50°C
As-welded	560-650	460-570	24 min.	120-200	40 avg.

PACKING DATA				
Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	49	86	115	240
Cartons / box	4	4	4	4
Pcs per box, Nos	196	344	460	960
Approx. Wt. of 1000 pcs,kg	100	58	44	21