

TENALLOY 65

CLASSIFICATIONS

AWS A/SFA 5.5 E9018-G

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

5.0	4.0	3.2
190-250	140-180	100-140

IDENTIFICATION: Name Printed

WELDING POSITIONS

F, H, V-up, OH

CHARACTERISTICS

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

REDRYING CONDITIONS

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

TYPICAL APPLICATIONS

Welding of high tensile steels, pressure vessels, boilers and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining A,B,C grades of SA-662/662M

WELD METAL CHEMISTRY, (%)

C - 0.09 max.	S - 0.030 max.	Diffusible H ₂
Mn - 1.20-1.70	P - 0.030 max.	Content <5ml/100gm
Ni - 1.10-1.60	Mo - 0.25-0.40	of weld metal

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Pcs per carton, Nos	49	77	112
Cartons / box	4	4	4
Pcs per box, Nos	196	308	448
Approx. Wt. of 1000 pcs,kg	100	64	44

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd) 20-24	CVN Impacts, J 20°C -40°C
As-welded	630-700	550-620	20-24	150-200 80-120



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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