TENALLOY 70

CLASSIFICATIONS
AWS A/SFA 5.5   E9018-G

IDENTIFICATION: Name Printed

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.

TYPICAL APPLICATIONS

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

CURRENT CONDITIONS: AC (90V), 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
300^0C for 1 Hr (Optionally also available in vacuum-packed condition.)

WELD METAL CHEMISTRY, (%)

C - 0.05-0.09	S - 0.030 max.	Diffusible H_2
Mn - 1.20-1.60	P - 0.030 max.	Content < 5 ml/100gm
Si - 0.40-0.70	Ni - 0.50-0.75	of weld metal

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	49	76	111	232
Cartons / box	4	4	4	4
Pcs per box, Nos	196	304	444	928
Approx. Wt. of 1000 pcs,kg	100	65	45	22

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J	
	MPa	MPa	(L =4xd)	27^0C	-30^0C
As-welded	630-700	550-620	22-26	140-200	40-70