TENALLOY 75

CLASSIFICATIONS
AWS A/SFA 5.5 E10018-M

IDENTIFICATION: Name Printed

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

APPROVALS
ABS E 10018-M H4

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^{0}C for 1 Hr (Optionally also available in vacuum-packed condition.)

TYPICAL APPLICATIONS
Welding of high tensile steels e.g. USS T-1, N-A-XTRA 70, BH65 used for fabrication of penstocks, earth moving equipments and heavy structures subject to dynamic loading and mechanical restraint.

WELD METAL CHEMISTRY, (%)		
C - 0.05 - 0.10	S - 0.030 max.	Diffusible H_2
Mn - 1.30 - 1.80	P - 0.030 max.	Content < 5 ml/ 100gm
Mo - 0.50 max.	Ni - 1.25-2.50	of weld metal
Si - 0.25 - 0.60		

PACKING DATA				
Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	48	77	116	230
Cartons / box	4	4	4	4
Pcs per box, Nos	192	308	464	920
Approx. Wt. of 1000 pcs,kg	104	64	43	22

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J
	MPa	MPa	(L=4xd)	-50^{0}C
As-welded	710 min	610 min	20 min	30-70