

TENALLOY Ni

CLASSIFICATIONS

AWS A/ SFA 5.5 E7018-G

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy coated, hydrogen-controlled iron powder low-alloy steel electrode specially designed for high impact values at sub-zero temperatures. Can also be used on mild steel applications where the structures have to withstand sub-zero temperatures. The electrode gives an extremely smooth arc, medium penetration, least spatter with an easily removable slag. Deposition efficiency approximately 110%.

TYPICAL APPLICATIONS

• Low-alloy steels such as Si-Mn steels and containing Ni up to 1.0% for heat treated steels. • For heavy joints under restraint and subject to dynamic loading for low temperature applications, etc.

WELD METAL CHEMISTRY (%)

C - 0.05 - 0.09 Ni - 0.45 - 0.80
 Mn- 1.20 - 1.70 S - 0.03 max
 Si - 0.20 - 0.48 P - 0.03 max
 Diffusible H₂ content ml/100 gm <5

MECHANICAL PROPERTIES - ALL - WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd) 24-28
As-welded	520-620	430-540	

CURRENT CONDITIONS : AC (90V) or DC (+)

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

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

IMPACT PROPERTIES OF PURE WELD METAL AT SUB-SERO TEMPERATURES

°C	J
-50	30-70

PACKING DATA

	5.0	4.0	3.2	2.5
Dia., mm	450	450	450	350
Length, mm	49	75	119	222
Pcs per carton, Nos	4	4	4	4
Cartons / box	196	300	476	888
Pcs per box, Nos	102	67	42	23
Approx. Wt. of 1000 pcs,kg				



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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