TENALLOY 55

LOW ALLOY STEEL (LOW TEMPERATURE)

AWS A/SFA 5.5 **E8018-G**

CLASSIFICATION

EN ISO 2560-A
E 46 5 Mn1Ni B 12 H5

KEY FEATURES

- Basic coated electrode
- Excellent fracture toughness down to -50°C
- Resist atmospheric corrosion
- Weld metal is tough & highly crack resistant
- Radiographic quality weld
- Suitable for positional welding

APPROVALS: IBR/CE

TYPICAL APPLICATIONS

- Suitable for joining steels containing 1% Ni and 0.5% Cu
- Storage tanks, Pipes
- Pressure vessels, Boilers
- Bridges, Heavy structures

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni
0.07	1.7	0.3	0.9

MECHANICAL PROPERTIES OF ALL WELD METAL

	Condition	UTS, Mpa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	610	570	25	55
Specification		550 min	460 min	19 min	47 min

Diffusible H2 Content: <5 ml/100 gm

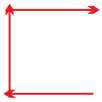
PARAMETERS - PACKING DATA

Ø mm	Amperage, A
2.5 x 350	60-90
3.15 x 450	100-140
4.0 x 450	140-180
5.0 x 450	190-250

AC (70 OCV)/DCEP

REDRYING CONDITION
250-300OC for minimum 1 hr.

All Positions, except vertical Down



Available in Standard carton packing of 20 kg box containing 4 cartons 5 kg each. Also available in vacuum packing