



# Tenalloy 16 Spl

C-Mn STEEL (Low Hydrogen)

## Welding Electrode specially for Nace Quality Carbon Steel Welding

CLASSIFICATION : EN ISO 2560-A      AWS A/SFA 5.1

E 42 5 B 12 H5      E 7016-1H8R

### KEY FEATURES :

- Medium coated basic electrode
- Moisture resistant coating
- Weld metal resistant to cold and hot cracking and tri-axial stressing
- Positional welding characteristics with medium coating ideal for full penetration root run in pipe welding
- DCEN preferred for root run welding of pipes

WELDING POSITION :



AC (60 OCV)/ DCEP / DCEN

### TYPICAL APPLICATIONS :

- One side welding of pipes
- Horton spheres, Penstocks
- Carbon steel and low alloy steel pressure vessels fabrications and where severe service conditions exist
- For NACE quality carbon steel pipes
- Off-shore process platform structures
- Medium, high tensile structural steels
- Heavy sections and restrained joints in high tensile structural steels

REDRYING CONDITION : 300°C for 2 hr.

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.07	1.2	0.3	0.01	0.01
Specification	0.05-0.10	1.0-1.40	0.15-0.48	0.012 max.	0.015 max.

### 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	550	470	25	52
Specification		510-600	420-530	24-29	40-60

Diffusible H<sub>2</sub> Content: <5 ml/100 gm

SPECIAL TEST : HIC & SSCC (NACE)

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	281	4	17
3.15 x 450	90-140	132	4	37
4.0 x 450	140-180	85	4	58
5.0 x 450	180-250	55	4	90