**LOW HYDROGEN IRON POWDER ELECTRODE**
**FOR Ni-Cr-Mo HIGH TENSILE STEELS**

# EURO TENSAL

**CODING**

AWS: E 11018-M

**CHARACTERISTICS:**

Euro Tensal is a heavy coated low hydrogen Iron powder type electrode suitable for welding low alloy high tensile steels having tensile strength of 110,000psi and more, nickel steels, molybdenum steels and creep resisting high tensile steels. The electrode can be operated equally well on AC as well as DC+.

**NOTED FEATURES:**

1. Specially designed for low alloy, high tensile heat and creep resisting steels.
2. Radiographic quality weld metal which is tough, ductile and resistant to cracking.
3. Suitable for service temp as low as minus 50°C and as high as 500°C
4. Good burning with steady and stable arc.
5. Easily detachable slag,uniform and fine rippled bead.

**USES:**

Euro Tensal can be used for welding low-alloy high tensile steels. T1 steels, Hy-90 steels, 555-100 steels, nickel steels, nickel molybdenum steels, boilers, pressure vessels, storage tanks for liquefied gases, pipe line, high temp reaction vessels, heavy structures etc.,

**RECOMMENDED CURRENT RANGES:**

| SIZE mm | | 2.50X350 | 3.15 X 350 | 4.00 X 350 | 5.00 X 350 |
|---|---|---|---|---|---|
| CURRENT-Amps | AC70/DC(+) | 60-100 | 100-140 | 140-190 | 200-260 |

**CHEMICAL ANALYSIS OF THE WELD METAL :**

| **Element** | C | Mn | Si | Ni | Mo | S | P | Cr |
|---|---|---|---|---|---|---|---|---|
| % | 0.07 | 1.52 | 0.32 | 1.87 | 0.45 | 0.018 | 0.019 | 0.31 |

**TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL**

| UTS $N/mm^2$ | % Elongation | CVN Impact value(J) |
|---|---|---|
| 600-820 | 22-24 | 80-100(at + 27°C)<br>40-60(at - 50°C) |

**SPECIAL INSTRUCTIONS:**

1. Ensure that electrodes are dry before use.
2. Rebake electrode @ 350°C for one hour to remove moisture. Then cool to around 100°C and maintain @ 100°C before use.
3. Use small gauge electrodes to avoid excess heat and to avoid cracking.
4. Cool the job slowly.