

## TENSAL-MH

**CODIFICATION :** AWS : SFA 5.5 E9018-M

### CHARACTERISTICS AND APPLICATIONS :

Extra low hydrogen type electrodes depositing a high strength weld metal. Ideally suited for welding fine-grained steels, high strength steels, Q&T steels used in the fabrication of structures, bridges, penstocks and other components.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Ni	Mo	S	P
Percent	: 0.06	1.20	0.35	1.60	0.30	0.018	0.018

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 51 °C (Joules)
644	554	26	50

### CURRENT AND PACKING DATA: DC(+)

Size(mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range (Amps)	:	280-350	200-250	140-190	100-140	80-100
Qty.(Pcs./Carton)	:	25	30	50	75	100

### APPROVAL: CIB- MP

### PRECAUTIONS:

1. During welding keep the heat input to a minimum.
2. Ensure the electrodes are dry. Rebake electrode at 400°C for one hour before use.