

PRODUCT DATA SHEET

Metrode Tufmet INi.B



Tufmet INi.B is designed to weld higher strength structures where PWHT is not practicable so that welds must possess an appropriate degree of toughness and crack resistance. Also recommended where design requirements specify toughness testing of higher strength low alloy steel welds down to -50°C.

Classifications		
AWS	A5.5	E8018-C3
EN	2560-A	E 46 6 INi B42
EN	2560-B	E5518-N2 A U

Typical Chemical Analysis			
% Carbon	0,05	% Chromium	0,05
% Manganese	1,0	% Molybdenum	0,1
% Silicon	0,3	% Nickel	0,9
% Sulphur	0,015	% Vanadium	0,01
% Phosphorous	0,015		

Typical Mechanical Properties (All weld metal in the as welded condition)	
Tensile Strength	610 MPa
0,2% Proof Strength	520 MPa
% Elongation on 5d	25
Charpy V-Notch at -20°C	150 J
Charpy V-Notch at -40°C	120 J
Charpy V-Notch at -50°C	80 J
Charpy V-Notch at -60°C	65 J

Packing Data (DC+)				
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	70 - 110	350	3 x 4,0	W078214
3,15	80 - 130	380	3 x 4,5	W078216
4,0	120 - 180	450	3 x 5,6	W078218

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