TAC-16

Characteristics and Applications:

TAC-16 is for the welding of 490N/mm² grade high tensile weathering steel. The welding can be done in all positions with good atmospheric corrosion resistance, good X-ray soundness, and good crack resistance. The weld metal contains Cu and Ni. It is suitable for 490N/mm² high tensile steel (ASTM A588,COR-TEN A, B), and also for SPA-H, SMA 490 steel.

Notes on usage:

- 1. Dry the electrodes at 350-400 for 60 minutes before using.
- 2. Do not exceed the range of recommended current. Over heat input might decrease the impact value.
- 3. Maintain short arc length. Moving range should be controlled within 3 times of the wire's dia when you are welding with weave method.
- 4. While applying in plate with high restraint (such as the plate is thicker than 25mm), pre-heating at 80~100 is recommended.
- 5. Be sure to clean up the contaminations on the base metal and welding seam so as not to derogate the weld metal quality from particles.
- 6. Use back-step method to prevent arc starting from blowholes and hold for 3-5 seconds at every end-up.

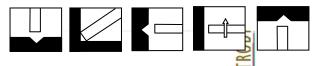
Typical chemical composition of weld metal (wt%):

С	Mn	Si	Р	S	Cu	Ni	Cr	
0.06	0.60	0.50	0.018	0.010	0.5	0.35	0.25	

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -20°C (0)	
515(75)	610(88)	30	140(103)	

Welding position:



Sizes and recommended current range (AC or DC +):

	Diameter (mm) Length (mm)		3.2	4.0		5.0	
			350	'ER	450	450	
Amps	A	F	100-140	COV	140-180	180-230	
	V&OH	90-110		130-160	-		

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