

TNH-58

AWS A5.5 E8018-C3 H4
EN ISO 2560-A-E 46 4 1Ni B 1 2 H5
JIS Z 3211 E5518-N2 H5

Characteristics and Applications:

TNH-58 is an iron powder low hydrogen electrode for the welding of low temperature service steel in all positions. The weld metal contains 0.9%Ni. It is suitable for the welding of LPG tanks. The welding provides good X-ray soundness, high deposition rate, good impact value at -40°C , and less than 4 ml/100g hydrogen content. Proper base metals are also including high-carbon steel, low Manganese alloy steel, 540~610N/mm² high tensile steel, cast iron, steel pipe for low temperature service, pressure vessel, ASTM A225 Gr D/A333 Gr1&6/A607 Gr60/A707 Gr.L5.L6, etc..

Notes on usage:

1. 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.
2. Maintain short arc length. Moving range should be controlled within 3 times of the wire's dia when you are welding with weave method.
3. Dry the electrodes at $350\sim 400^{\circ}\text{C}$ for 60 minutes before using. Take out a batch of half day consumption and keep at $100\sim 150^{\circ}\text{C}$ during welding process.
4. Do not exceed the range of recommended current. Over heat input might decrease the impact value.
5. Pre-heat at $50\sim 100$ while in welding thick plate.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Ni
0.05	0.75	0.4	0.018	0.01	0.82

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -40°C (-40°F)
505(73)	580(84)	30	150(111)

Welding position:



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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	100-140	140-180	180-230
	V&OH	80-110	130-160	-

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should be considered as recommendation for any welding condition or technique and controlled

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