

# TALARC C3

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.5: E8018-C3	EN ISO 2560-A: E46 4 1Ni B 3 2

## ALLOY TYPE

1% Ni content to be used for the welding of high strength, 1% Ni steels.

## APPLICATIONS

Low alloy basic-coated electrode alloyed with 1%Ni, to be used for the welding of high strength steels. Applications for this electrode include Shipbuilding, piping and gas storage tanks, pipelines and weathering steels. It is Ideal for welding LNG storage tanks or 1%Ni steel for low temperature resistance.

## TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Ni %
0.065	0.65	0.62	0.015	0.010	0.94

## TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	0°C	-20°C	-30°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
As welded	520	590	32	-	-	-	88	-

## WELDING GUIDELINES

Preheat/interpass and PWHT depend on material type/thickness and job requirements. To be reconditioned at 300÷350°C for two hours (max 3 times) if necessary.

## TECHNICAL INFORMATION

Welding positions: all positions except vertical down



## WELDING PARAMETERS

Current	AC /DC + Reverse polarity		
Diameter (mm)		3.2	
Length (mm) *		350	
Intensity (A)		90 ÷ 140	

Diam.	Pack/Carton	Part No.
3.2mm	2kg VAC pack/12kg	INEC332

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