

# TRU TUF 300, 360, 400

## WELDING AND FORMING INSTRUCTIONS

### Forming:

When forming use an inside bend radius of at least 10t (where t is the plate thickness), with the bend axis transverse to the rolling direction (i.e., across the grain), for thickness up to and including 0.787"

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### Maximum temperatures for hot forming and stress-relief:

**TRU TUF** can be heated to approximately 480° F for about 10 minutes, for hot forming or stress relief operations. Additional time at this temperature may result in some loss of mechanical properties.

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### Welding:

**TRU TUF** exhibits excellent weldability, because of its low alloy content.

This grade can be welded using simple procedures and common, readily available consumables. **TRU TUF** recommends low-hydrogen electrodes (a maximum of 10 ml per 100 gm of weld deposit).

High heat input welding processes such as electroslag and electrogas are not suitable of **TRU TUF**, since they will reduce mechanical properties and hardness along the heat-affected zone.

<b>thickness</b>	<b>nominal aim carbon equivalent</b>	<b>maximum carbon equivalent</b>
<b>0.236" up to 2.0"</b>	<b>0.40</b>	<b>0.48</b>

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The carbon equivalent on the mill test report should be used for critical calculations.

## Preheat and interpass temperatures

**TRU TUF** recommends the following preheat and interpass temperatures, which should be monitored with temperature crayons, thermocouples, etc. Higher preheat temperatures may be required when there is less control of the hydrogen level, or when higher joint restraint is present.

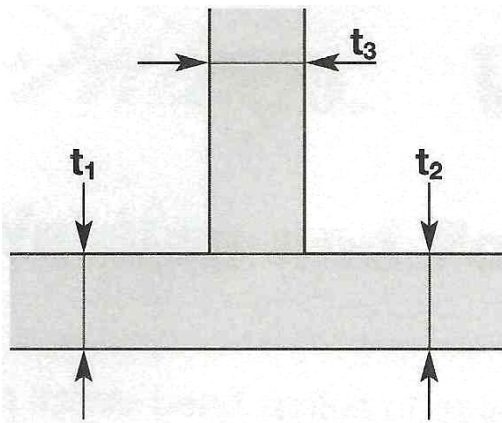
### Combined plate thickness

<b>*(t1 + t2 + t3)</b>	<b>low restraint</b>	<b>high restraint</b>
<b>&lt;= 2.25"</b>	<b>no preheat</b>	<b>165° F</b>
<b>&lt;= 3.00"</b>	<b>165° F</b>	<b>210° F</b>
<b>&lt;= 4.00"</b>	<b>210° F</b>	<b>300° F</b>
<b>&gt; 4.00"</b>	<b>255° F</b>	<b>300° F</b>

These temperatures are based on the SMAW process, using E7018 electrodes. Once the electrodes are removed from the sealed containers, they should be stored in an oven at 250° F.

Preheat temperatures can be reduced by 50° F for the GMAW process.

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Combined Plate Thickness:

T Joint:  $t = t_1 + t_2 + t_3$

Butt Joint:  $t_3 = 0$