

# TENAX 118D2

## TOP FEATURES

- Used for applications with a higher yield strength up to 600 Mpa and down to -40°C.
- Easy striking.
- 120% Efficiency.

## CLASSIFICATION

AWS A5.5 E10018-D2 H4  
EN ISO 18275-A E 62 4 Mn1NiMo B T 32 H5

## CURRENT TYPE

AC, DC+

## WELDING POSITIONS

All position, except vertical down

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni	Mo
0.08	1.8	0.3	0.025	0.02	0.8	0.35

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition*		Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.5	AW	≥600	≥690	≥16	≥27
EN ISO 18275-A	AW	≥620	760-960	≥18	not specified
Typical values	AW	700	780	24	100
	PWHT 620°C/1h	620	760	24	80

\* AW = As welded, PWHT = Post Weld Heat Treatment

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65-90
3.2x350	95-130
4.0x450	130-180

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	100	2.0	W100258333
3.2 x 350	VPMD	55	1.9	W100258334
3.2 x 450	VPMD	TBD	2.5	W200258334
4.0 x 450	VPMD	35	2.3	W100258335
5.0 x 450	VPMD	TBD	2.1	W100258336

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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