

TENACITO R

TOP FEATURES

- The weld metal is of extremely high metallurgical purity, is ageing-resistant, retaining ISO-V toughness to -60°C and CTOD tested.
- Welds are of X-ray quality.
- Due to the double coating of the 2.5 mm and 3.2 mm sizes, the arc is both stable and concentrated, even at lower welding currents when positional welding, with good gap bridging characteristics.

CLASSIFICATION

| | |
|---------------|----------------|
| AWS A5.5 | E7018-1 H4 |
| EN ISO 2560-A | E 42 6 B 42 H5 |

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

| ABS | LR | BV | DNV | TÜV | DB |
|-----|----|----|-----|-----|----|
| + | + | + | + | + | + |

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

| C | Mn | Si | P | S |
|------|------|-----|--------|--------|
| 0.06 | 1.45 | 0.3 | ≤0.012 | ≤0.012 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) -60°C |
|----------------|------------------|----------------------|------------------------|----------------|------------------------|
| AWS A5.1 | AW | ≥400 | ≥490 | ≥22 | not specified |
| EN ISO 2560-A | AW | ≥420 | 500-640 | ≥20 | ≥47 |
| Typical values | AW | 440 | 580 | 25 | 90 |
| | PWHT 580°C x 15h | 420 | 550 | 25 | 90 |

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

OUTPUT RANGE

| Diameter x Length (mm) | Current range (A) |
|------------------------|-------------------|
| 2.5x350 | 65-95 |
| 3.2x350 | 90-140 |
| 3.2x450 | 90-140 |
| 4.0x450 | 140-185 |
| 5.0x450 | 160-240 |

PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|------------------------|-----------|-----------------|----------------------|---------------------------|
| 2.5 x 350 | VPMD | 110 | 2.1 | W000287418 |
| 3.2 x 350 | VPMD | 60 | 2.1 | W000287419, W000404202 |
| 3.2 x 450 | VPMD | 60 | 2.8 | W000287420, W000403915 |
| 4.0 x 450 | VPMD | 35 | 2.3 | W000403916 |
| | VPMD | 35 | 2.4 | W000258297 |
| 5.0 x 450 | VPMD | 20 | 2.2 | W000258298, W000403917 |

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.
Please refer to www.lincolnelectric.eu for any updated information.