TENAX 70

TOP FEATURES

- 100% efficiency.
- Excellent operability.

CLASSIFICATION

AWS A5.5	E8018-G H4
EN ISO 2560-A	E 50 6 Mn1Ni B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	DNV
+	+	+

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

C	Mn	Si	P	S	Ni
0.06	1.2	0.5	≤0.020	≤0.015	1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW	≥460	≥550	≥19	not specified
EN ISO 2560-A	AW	≥500	560-720	≥18	≥47
Typical values	AW	520	650	22	60
	PWHT 620°C x 1h	460	570	22	65

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	130-150
4.0 x 450	160-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	87	2.0	W000403802
3.2 x 350	VPMD	54	2.0	W000403803
4.0 x 450	VPMD	37	2.5	W000403804
	CBOX	81	5.5	W000258309

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.