TENACITO 100

TOP FEATURES

- Good gap bridging characteristics.
- The double coating in dia 2,5 and 3,2mm confers a stable and concentrated arc, even at low currents, making it very convenient for root passes and positional welding.
- Good X-ray soundness.

CLASSIFICATION

AWS A5.5	E12018-G H4
EN ISO 18275-A	E 89 4 Mn2Ni1CrMo B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.07	1.7	0.4	≤0.012	≤0.012	0.8	2.45	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.5	AW	≥740	≥830	≥18	not specified
ISO 18275-A	AW	≥890	980-1080	≥17	≥47
Typical values	AW	980	1000	17	55

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	90-135
4.0 x 450	140-185

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.