

TENAX 35S

TOP FEATURES

- Excellent X-ray soundness.
- Efficiency 120%.
- Excellent mechanical properties.

CLASSIFICATION

AWS A5.1 E7018-1 H4
EN ISO 2560-A E 42 5 B 32 H5

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	RINA	TÜV	DNV
+	+	+	+

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

C	Mn	Si	P	S
0.075	1.35	0.35	≤0.02	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47/-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	465	540	29	150
	PWHT 620°C/1h	450	530	30	120

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	25-50
2.5 x 300	60-95
2.5 x 350	60-95
3.2 x 350	90-130
3.2 x 450	85-135
4.0 x 450	110-195
5.0 x 450	175-220
6.0 x 450	210-280

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 300	CBOX	275	3.6	W000380285
2.5 x 300	VPMD	90	1.8	W000380314
	CBOX	180	3.7	W000380286
2.5 x 350	VPMD	90	2.2	W000287341
	CBOX	180	4.3	W000380289
3.2 x 350	VPMD	55	2.1	W000287342
3.2 x 450	VPMD	55	2.8	W000287343
	CBOX	115	5.8	W000380291
4.0 x 450	VPMD	40	2.9	W000287344
	CBOX	80	5.8	W000380293
5.0 x 450	VPMD	25	2.7	W000287345
	CBOX	55	5.9	W000380295
6.0 x 450	CBOX	40	6.0	W000380312

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.