TENAX 58S

TOP FEATURES

- Good Mechanical Properties
- Deposit free from porosity, excellent slag detachability in position.
- Hydrogen < 5ml H_2/100g deposited weld metal.

CLASSIFICATION

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

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV	RINA	TÜV
+	+	+

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

C	Mn	Si	P	S
0.06-0.1	0.8-1.5	≤0.5	≤0.02	≤0.02

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	450	550	24	80
	PWHT 620°C x 1h	420	500	23	70

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	65-90
2.5x350	65-90
3.2x450	100-140
4.0x450	140-190
5.0x450	190-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	185	3.5	0D10522012
2.5 x 350	CBOX	185	4.1	0D10522212
3.2 x 450	CBOX	120	5.5	0D10522015
4.0 x 450	CBOX	85	5.8	0D10522016
5.0 x 450	CBOX	55	5.5	0D10522018

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.