

# TENCORD 85 Kb

## TOP FEATURES

- The weld deposit has a very similar appearance to Cor-Ten A steel
- Suitable for positional welding and welding with an inverter power source
- Very low diffusible hydrogen content

## CLASSIFICATION

AWS A5.5	E8018-G H4
EN ISO 2560-A	E 50 4 Z B 32 H5

## CURRENT TYPE

AC, DC+

## WELDING POSITIONS

All positions, except vertical down

## APPROVALS

RINA

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

C	Mn	Si	P	S	Cr	Ni	Cu
0.06	1.3	0.4	≤0.02	≤0.02	0.5	0.45	0.45

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.5	AW	540-620	≥620	≥24	≥27
EN ISO 2560-A	AW	≥500	560-720	≥18	≥47
Typical values	AW	650	700	24	90
	PWHT	460	650	23	60

AW = As welded, PWHT = Post Weld Heat Treatment 620°C/1h

## OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-90
3.2 x 350	80-140
4.0 x 450	110-180

## AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	88	1.8	W100287584
3.2 x 350	VPMD	53	2.1	W100287585
4.0 x 450	VPMD	39	2.8	W100287586

### 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.  
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