

# 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 18275-A	E 50 4 Z B 32 H5

## CURRENT TYPE

AC, DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

RINA	TÜV
+	+

## 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 18275_A	AW	≥500	560-720	≥18	≥47
Typical values	AW	650	700	24	90
	PWHT 620°C/1h	460	650	23	60

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

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	60-90
3.2x450	80-140
4.0x450	110-180

## PACKAGING AND AVAILABLE SIZES

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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