TENACITO 80CL

TOP FEATURES

- Low-alloyed basic coated MMA electrode with a low hydrogen content for high strength steels
- The electrode produce a reliable, crack-free and tough welded joint on steels with a yield strength <700 Mpa
- The weldmetal is of extremely high metallurgical purity
- Good X-ray soundness
- Good gap bridging characteristics

CLASSIFICATION

AWS A5.5	E11018-G H4
EN ISO 18275-A	E 69 6 Z B 32 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions, except vertical down

APPROVALS

ABS	DNV	TÜV	DB
+	+	+	+

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.08	1.75	0.4	0.01	0.005	0.15	2.5	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW	≥670	≥760	≥15	-
EN ISO 18275-A	AW	≥690	760-960	≥17	≥47
Typical values	AW	760	840	18	80
	PWHT 580°C x 15h	650	700	17	47

AW = As welded, PWHT = Post Weld Heat Treatment

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	80-130
4.0 x 450	110-180
5.0 x 450	160-240

AVAILABLE SIZES AND PACKAGING

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	110	2.2	W100287467
3.2 x 350	VPMD	60	2.1	W100287468
4.0 x 450	VPMD	40	2.7	W100258325
5.0 x 450	VPMD	20	2.1	W100258326

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.