

TENACITO 80CL

TOP FEATURES

- The weld metal is of a extremely high metallurgical purity, retaining good CVN toughness up to -60°C. For optimal conditions a good balanced t8/5: (heat input, interpass temperature, plate thickness) is recommended.
- The TENACITO 80CL is used for HYSS, applications with a higher yield strength up to 700 Mpa and down to -60°C.
- The welds are of X-ray quality.

CLASSIFICATION

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

CURRENT TYPE

DC+

WELDING POSITIONS

All position, 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	not specified
EN ISO 18275-A	AW	≥690	760-960	≥17	≥47
Typical values	AW	760	840	18	80

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65-95
3.2x350	80-130
4.0x450	110-180
5.0x450	160-240

PACKAGING AND AVAILABLE SIZES

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.