TENAX 88S

TOP FEATURES

- Yield strength < 450MPa. BS 4360-55 e/f and e 450 EMZ. With a high impact energy (down to -60°C) and fracture (CTOD) toughness in the as welded and stress relieved conditions.
- Excellent operability in all welding positions.
- 100% efficiency.

CLASSIFICATION

AWS A5.5	E8016-G H4
EN ISO 2560-A	E 50 6 Mn1Ni B 12 H5

CURRENT TYPE

AC, DC-, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	DNV
+	+	+

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

C	Mn	Si	P	S	Ni
0.06	1.7	0.4	≤0.02	≤0.02	0.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW	≥460	≥550	≥19	not specified
EN ISO 2560-A	AW	≥500	560-720	≥18	≥47
Typical values	AW	550	640	26	90
	PWHT 620°C x 1h	460	560	26	100

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	55-85
3.2x350	80-140
4.0x450	110-180
5.0x450	180-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	100	2.0	W000287539
3.2 x 350	VPMD	65	2.0	W000287540
4.0 x 450	VPMD	45	2.7	W000287542
5.0 x 450	VPMD	30	2.8	W000287543

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.