TENACITO 65R

TOP FEATURES

- Very convenient for root passes and positional welding.
- Good gap bridging characteristics.
- Good X-ray soundness

CLASSIFICATION

AWS A5.5	E9018-G H4
EN ISO 18275-A	E 55 6 Mn1NiMo B T 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	TÜV	DB
+	+	+

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

C	Mn	Si	P	S	Ni	Mo
0.05	1.6	0.3	≤0.012	≤0.012	0.9	0.35

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW	≥530	≥620	≥17	not specified
EN ISO 2560-A	AW	≥550	610-780	≥18	≥47
Typical values	AW	615	690	24	90

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	90-140
4.0 x 450	140-185
5.0 x 450	180-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	109	2.2	W000287435
3.2 x 350	VPMD	60	2.1	W000287436
	CBOX	125	4.3	W000384014
4.0 x 450	VPMD	34	2.3	W000258305
	CBOX	77	5.3	W000384016
5.0 x 450	VPMD	20	2.2	W000258306

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.