

# 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 positions, 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	-
EN ISO 2560-A	AW	≥550	610-780	≥18	≥47
Typical values	AW	615	690	24	90

AW = As welded

- = not specified

## 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
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.  
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