

TENACITO 70B

TOP FEATURES

- Very stable and concentrated arc
- Easy slag removal and mechanical properties in both the as welded and stress relieved conditions

CLASSIFICATION

AWS A5.5 E8018-C1 H4
EN ISO 2560-A E 46 6 2Ni B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions, except vertical down

APPROVALS

TÜV

+

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

C	Mn	Si	P	S	Ni
0.06	1.1	0.3	≤0.012	≤0.012	2.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5 PWHT	≥460	≥550	≥24	-
EN ISO 2560-A AW	470-550	530-680	≥20	≥47
Typical values PWHT	503	577	28	100

AW = As welded

PWHT: Postweld Heat Treatment 605°C/1 h

- = not specified

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	90-130
4.0 x 450	140-185

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	60	2.0	W000287452
4.0 x 450	VPMD	35	2.4	W000258317

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.