TENAX 98M

TOP FEATURES

- Especially used for main and especially military applications with a higher yield strength up to 550 Mpa and down to -60°C.
- Good striking.
- 110-120% Efficiency.

CLASSIFICATION

AWS A5.5	E9018M H4
EN ISO 18275-A	E 55 4 Z B 32 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Ni	Mo
0.07	1.2	0.4	≤0.02	≤0.02	1.6	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
AWS A5.5	AW	540-620	≥620	≥24	≥27
EN ISO 18275_A	AW	≥550	610-780	≥18	≥47
Typical values	AW	570	650	27	50

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	90-140
4.0 x 350	110-180
5.0 x 450	170-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	88	1.7	W100287520
3.2 x 350	VPMD	53	2.0	W100287521
4.0 x 350	VPMD	36	2.0	W100287522

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.