TENAX 56ST

TOP FEATURES

- Excellent impact at - 50°C.
- Excellent penetration and stable arc.
- Efficiency 100%.

CLASSIFICATION

AWS A5.5	E8018-G H4
EN ISO 2560-A	E 46 4 B 32 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All positions

APPROVALS

ABS
+

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

C	Mn	Si	P	S
0.06	1.7	0.5	≤0.025	≤0.025

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.5	AW	470-550	≥550	≥24	not specified
EN ISO 2560-A	AW	≥460	530-680	≥20	≥47
Typical values	AW	500	600	26	70
	PWHT 580°C x 15h	420	530	25	47

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	70-100
3.2x450	90-130
4.0x450	110-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	80	1.6	OETNX56ST25300VPMD
3.2 x 450	VPMD	54	2.7	OETNX56ST32450VPMD
4.0 x 450	VPMD	38	2.7	OETNX56ST40450VPMD

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.