TENAX 118D2

TOP FEATURES

- Used for applications with a higher yield strength up to 600 Mpa and down to -40°C
- Easy striking
- Recovery about 120%

CLASSIFICATION

AWS A5.5	E10018-D2 H4
EN ISO 18275-A	E 62 4 Mn1NiMo B T 32 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All positions, except vertical down

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

C	Mn	Si	P	S	Ni	Mo
0.08	1.8	0.3	0.025	0.02	0.8	0.35

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.5	AW	≥600	≥690	≥16	≥27
EN ISO 18275-A	AW	≥620	760-960	≥18	-
Typical values	AW	700	780	24	100
	PWHT 620°C/1h	620	760	24	80

AW = As welded, PWHT = Post Weld Heat Treatment

- = not specified

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	95-130
4.0 x 450	130-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	55	1.9	W100258334
4.0 x 450	VPMD	35	2.3	W100258335
5.0 x 450	VPMD	20	2.1	W100258336

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.