TENAX 35S R

TOP FEATURES

- Self releasing slag
- Efficiency 120%.
- Good X-ray soundness

CLASSIFICATION

AWS A5.1	E7018-1 H4R
EN ISO 2560-A	E 42 5 B 32 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	DNV	RINA	TÜV
+	+	+	+	+

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

C	Mn	Si	P	S
0.075	1.35	0.35	≤0.02	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47/-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	460	560	29	120
	PWHT 620°C x 1h	420	520	24	100

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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	60-95
2.5x300	60-95
2.5x350	60-95
3.2x450	90-130
4.0x450	110-170
5.0x450	175-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	VPMD	90	1.8	W000380325
2.5x350	CBOX	180	4.3	W000380320
3.2x450	VPMD	55	2.7	W000380327
	CBOX	115	5.7	W000380322
4.0x450	VPMD	40	2.8	W000380328
	CBOX	80	5.7	W000380323
5.0x450	CBOX	55	5.9	W000380324

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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.

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