TENAX 35S R

TOP FEATURES

- Self releasing slag
- Recovery about 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 positions, 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/1h	420	520	24	100

AW = As welded, PWHT = Post Weld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-95
3.2 x 450	90-130
4.0 x 450	110-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	86	1.7	W100380325
3.2 x 450	VPMD	53	2.5	W100380327
4.0 x 450	VPMD	37	2.5	W100380328

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.