

# TENAX 76C2L

## TOP FEATURES

- Suitable for welding pipes, tanks and containers.
- Very stable and concentrated arc and excellent mechanical properties in both the as welded and stress relieved conditions.
- Weld metal is of very low hydrogen content thus it provides high impact strength in service temperatures.

## CLASSIFICATION

AWS A5.5 E7018-C2L H4R  
EN ISO 2560-A E 42 6 3Ni 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	HDM
0.04	0.8	0.4	0.01	0.005	3.3	3 ml/100g

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-60°C	-80°C	-101°C
Required: AWS A5.5	PWHT**	min. 390	min. 480	min. 25			min. 27
EN ISO	AW	min. 380	470-600	min. 20	47		
Typical values	AW	490	570	30		90	
	PWHT**	420	510	30	120	90	70

\*AW = As welded; PWHT = Post weld heat treatment

\*\* 605±14°C/1h

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	60-90
3.2x350	90-140
4.0x350	125-180
5.0x450	180-240

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	90	1.8	W100287566
3.2 x 350	VPMD	60	2.3	W100287567
4.0 x 350	VPMD	40	2.2	W100287568
5.0 x 450	VPMD	28	2.9	W100287569

### 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](http://www.lincolnelectric.eu) for any updated information.