

TENACITO 80

TOP FEATURES

- Low-alloyed basic coated MMA electrode with a very low hydrogen content.
- The TENACITO 80 is used for HYSS, applications with a higher yield strength up to 700 Mpa and down to -60°C.
- The double coating in dia 2,5 and 3,2mm confers a stable and concentrated arc, even at low currents, making it very convenient for root passes and positional welding.
- Good gap bridging characteristics.
- Good X-ray soundness

CLASSIFICATION

AWS A5.5 E11018-G H4
EN ISO 18275-A E 69 6 Mn2NiCrMo B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV	TÜV
+	+

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.65	0.35	0.010	0.010	0.4	2.3	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-40°C	-60°C
AWS A5.5	AW	680-760	760	15	not specified	not specified
EN ISO 18275-A	AW	≥690	760-960	≥17	not specified	≥47
Typical values	AW	740	820	18	75	55

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65-95
3.2x350	90-135
4.0x450	140-185
5.0x450	180-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	TBD	2.2	W100287475
3.2 x 350	VPMD	55	2.1	W100287476
4.0 x 450	VPMD	40	2.8	W100258329

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.