

TENAX 118 is a basic coated MMA electrode for welding steels with a yield strength >700 MPa. The weld metal is of extremely high metallurgical purity, retaining good ISO-V toughness to -40°C. Very low hydrogen content.

Classification

EN	757: ~E 69 4 Mn2NiCrMo B 32 H5
AWS	A5.5: E 11018-G H4

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.7	0.4	≤ 0.020	≤ 0.012	0.4	1.7	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
As Welded	≥ 700	780-960	≥ 18	≥ 47

Materials

Welding of steels with a high yield strength (0.2% proof stress ≥ 700 MPa).

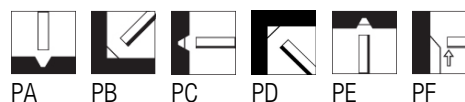
Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	DRYF	
				PC	Code
2.5	350	75-95	21.5	28	●
3.2	450	100-135	46.0	22	●
4.0	450	130-190	67.9	18	●
5.0	450	180-240	103.5	7	●