

TENAX 118-M is an all-positional low-hydrogen MMA electrode for welding high strength steels in the tensile strength range, 760-870 N/mm² e.g. T1, HY80, etc. The shortest possible arc and a low travel speed should be used as a low heat input is recommended. The low hydrogen weld metal minimises the risk of cold cracking. Efficiency 120%.

Classification	
EN	757: E 69 5 Z B 32 H5
AWS	A5.5: E 11018-M H4
AS/NZS	1553.2: E 7618-M H4R
GOST	9467-75:770-06?H2-6

Approvals	Grade
ABS	E11018-M
DNV	4Y69H5

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.07	1.6	0.3	≤ 0.02	≤ 0.02	2.3	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-60 °C
As Welded	≥ 690	760-960	≥ 20	≥ 70

Materials

T1; HY80; S(P)690

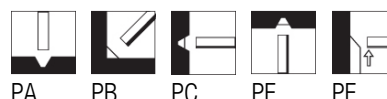
Storage

Keep dry and avoid condensation.

HD = 5: Re-dry at 400-420 °C for 1 hours, 3 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	55-105	16.6	90	●
3.2	350	90-140	34.3	55	●
4.0	350	110-180	52.7	40	●
5.0	450	150-210	108.1	20	●