

TENACITO 80 CL is a basic coated MMA electrode for reliable, crack-free and tough welded joints on steels with a yield strength <700MPa. The weld metal is of extremely high metallurgical purity, is ageing-resistant, retaining ISO-V toughness to -60°C. Very low hydrogen content. Due to the double coating of the 2.5 mm and 3.2 mm sizes, the arc is both stable and concentrated, even at lower welding currents when positional welding, with good gap bridging characteristics. Welds are of X-ray quality.

Classification	
EN	18275-A: E 69 6 Mn2NiCrMo B 42 H5
AWS	A5.5: E 11018-G H4

Approvals	Grade
ABS	

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.6	0.4	≤ 0.020	≤ 0.012	0.35	2.4	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				+20 °C	-40 °C	-60 °C
As Welded	≥ 720	760-900	≥ 17		≥ 80	≥ 60
580°C x 2h	≥ 650	700-850	≥ 17	≥ 120	≥ 60	

Materials

S(P)690

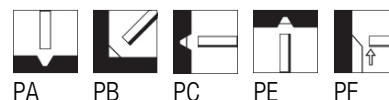
Storage

Keep dry and avoid condensation.

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

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	350	65-95	19.7	225	●	110	●
3.2	350	90-135	33.8	125	●	60	●
4.0	450	140-185	70.3	80	●	35	●
5.0	450	180-240	110.5	45	●	20	●