

TENAX 128-M is an all-positional low-hydrogen MMA electrode for the welding of high strength steels with yield strength <850 N/mm². Use the shortest possible arc and low travel speed as a low heat input is recommended. The low hydrogen weld metal minimises the risk of cold cracking. Efficiency 110-120%

Classification

EN	757: E 79 5 Mn2NiCrMo B 32 H5
AWS	A5.5: E 12018 – M
GOST	9467-75: ?85-08?2H2-6

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.08	1.6	0.35	≤ 0.015	≤ 0.015	0.45	1.9	0.4

All-weld metal Mechanical Properties

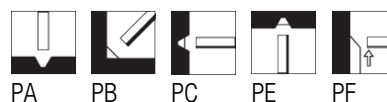
Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-51 °C
As Welded	≥ 740	880-1080	≥ 18	≥ 47
580 °C x 4 h	≥ 700	790-900	≥ 19	≥ 27

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	16.7	115	●
3.2	350	90-140	34.3	60	●
4.0	350	110-180	51.7	40	●