TENAX 128

CE

MMA Electrodes
High-strength steels

TENAX 128 is a basic coated MMA electrode for welding high-strength steels, with a yield strength <890 MPa, retaining ISO-V toughness down to -20°C. Very low hydrogen content.

Classification	
EN	757: ~ E 89 2 Mn2Ni1CrMo B 32 H5
AWS	A5.5: E 12018-G H4

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.08	1.7	0.4	≤ 0.020	≤ 0.010	0.6	1.9	0.8

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J) -20 °C
As Welded	≥ 950	1000-1180	≥ 15	≥ 47

Materials

Welding of steels with a high yield strength YS ≥ 900 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+

PA PB PC PD PE PF

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	DRYF PC	DRYF Code
3.2	450	100-135	45.8	22	●
4.0	450	140-190	67.5	18	●