

TENACITO 100 is a basic coated MMA electrode for reliable, crack-free and tough welded joints on high-strength steels, with a yield strength <890MPa, retaining ISO-V toughness down to -40°C. Very low hydrogen content, welds are of X-ray quality. 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.

Classification	
EN	757: E 89 4 Mn2Ni1CrMo B 4 2 H5
AWS	A5.5: E 12018-G H4

Approvals	Grade
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.07	1.7	0.4	≤ 0.012	≤ 0.012	0.8	2.45	0.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥ 890	980-1080	≥ 15	≥ 60	≥ 47

### Materials

S890

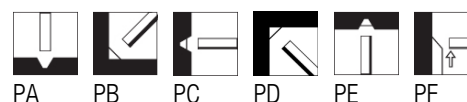
#### Storage

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)	VPMD	
				PC	Code
2.5	350	65-95	20.7	105	●
3.2	350	90-135	34.4	60	●
4.0	450	140-185	69.6	35	●
5.0	450	180-240	110.8	20	●