

MMA Electrodes C-Mn and low-alloy steels

TENACITO 70B is a basic coated MMA electrode for welding nickel-alloyed structural steels for low temperature service. The weld metal is of extremely high metallurgical purity, is ageing-resistant and deposits high ISO-V toughness weld metal to -80°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. Good gap bridging characteristics. Welds are of X-ray quality.

Classification	
EN ISO	2560-A: E 46 6 2Ni B 4 2 H5
EN	499: E 46 6 2Ni B 4 2 H5
AWS	A5.5: E 8018-C1 H4

Approvals	Grade
TÜV	●
CE	

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.06	1.1	0.3	≤ 0.012	≤ 0.012	2.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				+20 °C	-60 °C	-80 °C
As Welded	≥ 480	550-700	≥ 22	≥ 170	≥ 100	≥ 70
580°C x 15 h	≥ 420	520-640	≥ 20	≥ 170	≥ 80	≥ 47

Materials

12Ni14, S(P)275-S(P)460, 13 MnNi 6-3

Storage

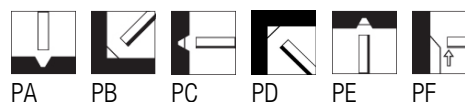
Keep dry and avoid condensation.

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

HD ≤ 10: Re-dry at 300-350 °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	19.1	225	●	110	●
3.2	350	90-130	34.4	125	●	60	●
4.0	450	140-185	69.5	80	●	35	●
5.0	450	180-240	112.2	45	●	20	●