

MMA Electrodes C-Mn and low-alloy steels

TENACITO 70 is a basic coated MMA electrode for reliable, crack-free and tough welded joints on steels with a yield strength <500MPa. The weld metal is of extremely high metallurgical purity, is ageing-resistant, retaining ISO-V toughness to -60°C. Very low hydrogen content. For applications with higher strength steels up to S(P) 500 and 16Mo3, MOLYCORD Kb could be used.

Classification	
EN	2560-A: E 50 6 Mn1Ni B 4 2 H5
EN	499: E 50 6 Mn1Ni B 4 2 H 5
AWS	A5.5: E 8018-G H4

Approvals	Grade
ABS	3H5-3Y
DB	●
DNV	4Y50 H5
GL	3Y H5
LRS	3m 5Y40m H5
RMRS	3YHHH
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.06	1.6	0.3	≤ 0.020	≤ 0.015	0.75

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-60 °C
As Welded	≥ 510	590-680	≥ 24	≥ 150	≥ 80
580°C x 1,5h	≥ 500	570-670	≥ 24	≥ 150	≥ 80

Materials

S(P)420-S(P)500; L245-L485

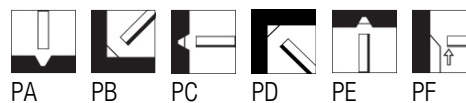
Storage

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	65-90	23.9	170	●	80	●
3.2	350	95-130	35.5	115	●	55	●
4.0	450	130-180	68.0	80	●	40	●
5.0	450	170-230	108.9	50	●	25	●