

TENAX 118-D2 is a basic coated MMA electrode for welding high yield strength steels, >600N/mm², when good impact toughness at low temperatures is required.

Classification

EN	757: E 62 4 Mn1NiMo B T 32 H5
AWS	A5.5: E 10018-D2

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.08	1.8	0.3	0.025	0.02	0.8	0.35

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)	
				-40 °C	-50 °C
620°Cx1h	≥ 620	690-890	≥ 18	≥ 47	-
As Welded	≥ 620	690-890	≥ 20	≥ 47	≥ 27

Materials

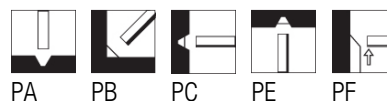
S(P)500

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+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	350	65-90	20.3	95	●
3.2	350	95-130	34.9	55	●
4.0	450	130-180	69.0	35	●
5.0	450	170-230	107.0	20	●