

TENACITO 38R is a low-hydrogen thick coated basic electrode that deposits weld metal containing C-1.2%Mn-0.9%Ni. Electrode producing tough and crack-free welded joints. Weld deposit is of extremely high metallurgical purity and very low hydrogen content. Owing to its double covering (up to 3,2 mm), the electrode features a stable arc, making it well suited for positional welding. CTOD-tested for offshore applications. Welds are of x-ray quality.

The electrode is suitable for positional welding of high integrity applications while conforming to NACE requirements. Suitable for welding micro-alloyed steels in high tech applications found in the offshore/nuclear industries.

TENACITO 38R electrode features a stable and concentrated arc making it well-suited for positional welding with excellent mechanical properties in both the as welded and stress relieved conditions. Weld metal is of very low hydrogen content thus it provides high impact strength in service temperatures.

Classification	
EN ISO	2560-A: E 46 6 1Ni B 42 H5
AWS	A5.5: E 7018-G H4

Approvals	Grade
ABS	5Y460H5
BV	5Y
DB	●
DNV-GL	5YH5
TÜV	●

CE

## Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.06	1.3	0.4	≤ 0.012	≤ 0.015	0.95

## 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	≥ 460	530-650	≥ 25	≥ 180	≥ 110
PWHT 580 °C x 15 h	≥ 420	500-650	≥ 25	≥ 180	≥ 90

## Materials

S(P)235-S(P)460; GP240-GP280; L245-L450

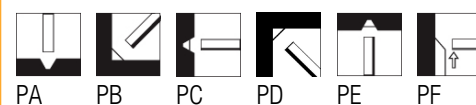
### Storage

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. weightn(kg/1000)	VPMD	
				PC	Code
2.5	350	65-95	19.18	110	W000287427
3.2	350	90-140	33.7	60	W000287428
4.0	450	140-185	69.91	35	W000258301
5.0	450	180-250	105	20	W000258302