

TENACITO 65R is a low-alloyed basic coated MMA electrode with a very low hydrogen content. The electrode produce a reliable, crack-free and tough welded joint on steels with a yield strength <550 MPa. The weldmetal is of a extremely high metallurgical purity, is ageing resistant, retaining good CVN toughness up to -60°C and CTOD tested. For sour gas applications, the nickel content is restricted to <1.0% max. On request, TENACITO 65R can be supplied to special quality assurance requirements, including KTA 1408.2.

TENACITO 65R is used for HYSS, Offshore, Sour gas and nuclear applications with a higher yield strength up to 550 Mpa and down to -60°C.

The double coating in diameters 2,5 and 3,2mm, confers a stable and concentrated arc, even at low currents, makes it very convenient for root passes and positional welding. Good gap bridging characteristics. The welds are of X-ray quality.

Classification	
EN ISO	18275-A: E 55 6 Mn1NiMo B T 42 H5
AWS	A5.5: E 9018-G H4

Approvals	Grade
ABS	E9018G
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Mo
0.05	1.6	0.3	≤ 0.012	≤ 0.012	0.9	0.35

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	≥ 550	630-750	≥ 20	≥ 150	≥ 47
PWHT 605 °C x 40 h	≥ 500	630-700	≥ 20	≥ 150	≥ 50

Materials

A508 Cl.2, A533 Gr. B Cl. 1, Cl.2, 13MnNiMo5-4, 17MnMoV6-4; L245-L555

S(P)355-S(P)555, 20MnMoNi5-5, 15NiCuMoNb5, 22NiMoCr3-7

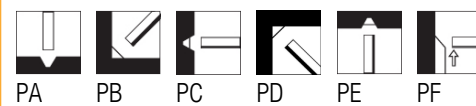
Storage

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	20.6	110	W000287435
3.2	350	90-140	34.3	60	W000287436
4.0	450	140-185	68.7	35	W000258305
5.0	450	180-240	111.7	20	W000258306