

TENACITO 70B is basic coated electrode producing tough and crack-free welded joints. Weld deposit is of extremely high metallurgical purity and very low hydrogen content. Due to its double coating (up to 3,2 mm), the electrode features a stable and concentrated arc, making it well-suited for positional welding. Welds are of X-ray quality. Basic Coated Electrode Depositing A 2.5%Ni Weld Metal For Welding Fine Grained Steels Where Impact Toughness Properties Down To -60 Deg C.

The electrode is suitable for welding Fine Grained Steels Where Impact Toughness Properties Down to -60°C. TENACITO 70B offers very stable and concentrated arc, easy slag removal and mechanical properties in both the as welded and stress relieved conditions.

Classification	
EN ISO	2560-A: E 46 6 2Ni B 42 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

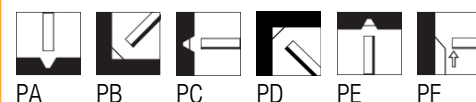
### Storage

Keep dry and avoid condensation.

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

### 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	19.1	110	W000287451
3.2	350	90-130	34.4	60	W000287452
4.0	450	140-185	69.5	35	W000258317
5.0	450	180-240	112.2	20	W000258318