

TENAX 78C1L is a low hydrogen Ni alloyed electrode, depositing high toughness weld metal. Used for the construction of tanks, etc. Use a short arc and low travel speed. The electrode is suitable for welding offshore oil and gas constructions.

TENAX 78C1L provides 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. Efficiency 120%.

Low hydrogen electrode for welding Ni alloy steels. The presence of nickel increases low temperature resilience.

Classification		Approvals	Grade
EN ISO	2560-A: E 42 6 2Ni B 32 H5	DNV	5YH5
AWS	A5.5: E 7018-C1L H4	RINA	5YDH5

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0,04	0,5	0,3	≤ 0,015	≤ 0,015	2,3

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-60 °C	-73 °C °C
As Welded	≥ 420	510 - 660	≥ 26	≥ 80	≥ 60
620 °C x 1h	≥ 420	≥ 460	≥ 26	≥ 110	

### Materials

12Ni14, S275-S420, P275-P460

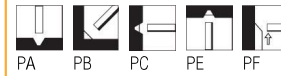
#### Storage

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. weightn(kg/1000)	VPMD	
				PC	Code
2,5	300	60-120	16,8	100	W000287553
3,2	450	100-140	47,0	60	W000287554
4,0	450	120-190	67,4	40	W000287555
5,0	450	180-250	103,1	25	W000287556