

# PRODUCT DATA SHEET

## Oerlikon Tenacito 70B



Oerlikon Tenacito 70B is a basic all position electrode containing 2,5% nickel for welding notch tough steels. It has good slag removal and a regular bead appearance. It is recommended for use in applications requiring low temperature toughness down to  $-60^{\circ}\text{C}$  and is also suited for welding weathering steels.

### Re-drying

Only dry electrodes should be used. Re-drying should be carried out at  $300-350^{\circ}\text{C}$  for 2 hours.

Classifications		
AWS	A5.5	E8018-C1
EN	2560-A	E 42 6 2Ni B H5

Typical Chemical Analysis			
% Carbon	0,06	% Nickel	2,4
% Manganese	1,0	% Copper	<0,09
% Silicon	0,4		

Typical Mechanical Properties (All weld metal in the as welded condition)		
	As Welded	PWHT $580^{\circ}\text{C}/15\text{ hr}$
Yield Strength	440 MPa	420 MPa
Tensile Strength	520 - 620 MPa	500 - 600 MPa
% Elongation on 5d	>24	>26
Charpy V-Notch at $+20^{\circ}\text{C}$	>160	>160
Charpy V-Notch at $-40^{\circ}\text{C}$	>90	>80
Charpy V-Notch at $-60^{\circ}\text{C}$	>70	>50
Charpy V-Notch at $-80^{\circ}\text{C}$	>40	>30
Charpy V-Notch at $-100^{\circ}\text{C}$	>00	-

Packing Data (DC+)				
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	65 - 95	350	5,0	WI12022
3,15	90 - 135	350	5,0	WI12023
4,0	140 - 185	450	5,0	WI12024
5,0	185 - 240	450	5,0	WI12025

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