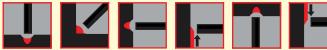
PRODUCT DATA SHEET

Oerlikon Tenacito













Tenacito 7018-1 is a low hydrogen, basic covered electrode for welding medium tensile strength structural and fine grained steels. It has excellent positional weldability and stable arc characteristics.

Re-drying Procedure

Use dry electrodes only. Re-drying should be carried out at 300-350°C for 2 hours.

Classifications					
Standards					
AWS	A 5.1	7018-1			
EN	2560	E 42 6B 42 H5			
Electrode Marking					
Tenacito	7018-1				

Approvals

Lloyds Register of Shipping Grade DXVuO,BF,3m,3Ym,H15

Typical Chemical Analysis (All weld metal)					
% Carbon	0,07	% Sulphur	<0,02		
% Manganese	1,2	% Phosphorous	<0,02		
% Silicon	0,4				

Typical Mechanical Properties (All weld metal in the as welded condition)				
Yield Strength	>440 MPa			
Tensile Strength	520 - 620 MPa			
% Elongation on 5d	gation on 5d >25			
Impact Strength at +20°C	>160 J			
Impact Strength at 0°C	>150 J			
Impact Strength at -20°C	>130 J			
Impact Strength at -40°C	>100 J			
Impact Strength at -60°C	>50 J			

Packing Data						
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number (Tenacito C5)	Item Number (Tenacito)	
2,5	65 - 95	350	5,0	W111472	W075372	
3,15	90 - 140	350	5,0	W111473	W075373	
4,0	140 - 185	450	5,0	W111474	W075374	
5,0	185 - 240	450	5,0	W111475	W075375	
6,3	240 - 340	450	5,0	-	W111066	

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