

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 | >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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