

MMA Electrodes High-strength steels

TENAX 98M is a basic coated electrode depositing low hydrogen weld metal with an efficiency of 110-120%. It is generally used for the welding of high strength steels with tensile properties of 600N/mm² min. The main applications are for the welding of root runs and standing fillets in higher strength steels.

Classification	
AWS	A5.5: E 9018-M H4
EN	757: E 55 5 Z B 32 H 5
GOST	9467-75:Э60-06ГН1-6

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.06	1	0.30	≤ 0.020	≤ 0.020	-	1.60	0.20	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -51°C	Hardness
As Welded	≥ 550	610-780	≥ 20	≥ 70	-

Materials

S(P)355-S(P)500; A508 Cl.2, A533 Cl.1Gr. B

Storage and redrying

Keep dry and avoid condensation.
HD ≤ 5: Re-dry at 400-420 °C for 1 hour, 3 times max.

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	55-105	16,0	9,6
3,2	350	90-140	36,0	21,6
4,0	350	110-180	53,1	31,8
5,0	450	170-240	110,7	66,4