

TENCORD 85CP

MMA Electrodes Weathering steels

Low Hydrogen electrode suitable for the welding of steels having high atmospheric corrosion resistance and high contents of P and Cu. Ideal for Cor-Ten A steel applications. Due to its characteristics of high atmospheric corrosion resistance and mechanical properties compared with a C-Mn steel, Cor-Ten is particularly suitable for movable structures, such as lorries, trailers, etc. Cor-Ten is also used in the bridge and construction industries because of the particular colour of its surface which does not require painting. The weld deposit has a very similar appearance to Cor-Ten A steel. Suitable for welding with an inverter generator. Efficiency 115%.

Classification	
AWS	A5.5: E 8018-G
EN	499: E 46 4 Z B 3 2 H10
EN ISO	2560-A: E 46 4 Z B 32 H10

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	0.70	0.40	≤ 0.020	≤ 0.020	0.50	0.40	-	-	-	-	0.40

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
PWHT 620°C x 1h	≥ 460	530-680	≥ 20	≥ 47	-
As Welded	≥ 460	530-680	≥ 20	≥ 47	-

Materials

CORTEN A-B-C; PATINAX; S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

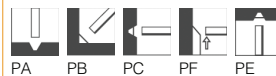
Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 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	60-90	20,2	12,1
3,2	450	80-140	49,8	31,8
4,0	450	110-180	71,1	46,6
5,0	450	160-240	106,7	64,0