

TENAX 58S General purpose basic coated low hydrogen electrode containing iron powder additions, suitable for positional welding. The weld appearance is excellent and spatter levels minimal. The excellent mechanical properties also make this electrode suitable for critical applications. Very good x ray quality. Efficiency 120%. Available in Vacuum Pack Only.

TENAX 58 S is suitable for unalloyed steels with low purity or higher carbon content, <0.4%C, and for buffer layers. Good welding characteristics, suitable for root passes and positional welding, welds are of X-ray quality. Material to be welded: EN 10025-3: S185, S235, S275, S355: P235, P265, P 335; S275, S 335, S420.

Good Mechanical Properties, Deposit free from porosity, excellent slag detachability in position. Hydrogen < 5mlH₂/100g deposited weld metal.

Weld metal recovery: ~120% .

DC and AC, welding current.

Low hydrogen electrode with iron powder in the coating. Low diffusible hydrogen content. Excellent mechanical characteristics and toughness. Used with machine structural work, ship hulls, petrochemical structures.

Classification	
EN ISO	2560-A: E 42 5 B 42 H5
AWS	A5.1: E 7018-1 H4

Approvals	Grade
DNV	3YH5
RINA	4YDH5
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.06-0.1	0.8-1.5	≤ 0.5	≤ 0.02	≤ 0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-50 °C
As Welded	≥ 400	490-550	≥ 24	≥ 80
620 °C x 1h	≥ 400	490 - 550	≥ 24	≥ 80

Materials

SA 516 gr.60; SA 516 gr.70; SA 106 gr.B

S(P)235-S(P)420, GP240-GP280

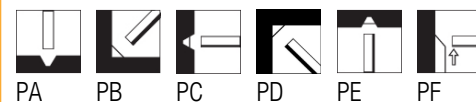
Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340°-360°C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
2.5	300	65-90	18.9	185	OD10522012
2.5	350	65-90	22.16	185	OD10522212
3.2	450	100-140	45.83	120	OD10522015
4.0	450	140-190	68.24	85	OD10522016
5.0	450	190-250	100.5	55	OD10522018