

# TENAX 35S



MMA Electrodes  
C-Mn and low-alloy steels

TENAX 35S is a 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 in such industries as offshore, nuclear and pressure vessels as well as the general construction industry. Very good x ray quality. Efficiency 120%.

### Classification

AWS	A5.1: E 7018-1 H4
EN	499: E 42 5 B 32 H5
EN ISO	2560-A: E 42 5 B 32 H5

### Approvals

### Grades

ABS
BV
DB
DNV
GL
LRS
MMI
RINA
TÜV

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.075	1.35	0.35	≤ 0.020	≤ 0.015	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -50°C	Hardness
PWHT 620°C x 1h	≥ 400	490 - 560	≥ 22	≥ 100	-
As Welded	≥ 420	510 - 640	≥ 22	≥ 100	-

### Materials

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

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

### Storage and redrying

Keep dry and avoid condensation.

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

HD ≤ 10: Re-dry at 350-370 °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	350	70-100	23.5	14.1
3.2	450	90-130	49.5	29.8
4.0	450	110-170	70.9	42.6

Diam.	Pack/Carton	Part No.
2.5mm	3.6kg/10.8kg	OER TENAX35S25
3.2mm	2.6kg/15.6kg	OER TENAX35S32
4.0mm	2.1kg/12.6kg	PH77VP40

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