

MMA Electrodes C-Mn and low-alloy steels

TENAX CY17 is a basic coated MMA electrode with very low diffusible hydrogen content for welding steels with a tensile strength <600 MPa. Recommended for welding very thick section or fully restrained assemblies. Very high impact toughness down to - 40 °C and CTOD tested. Applications include offshore drilling, boiler work, construction and repair of pressurised equipment.

Classification	
EN ISO	2560-A: E 42 5 B 32 H5
EN	499: E 42 5 B 3 2 H5
AWS	A5.1: E 7018-1

Approvals	Grade
ABS	3H10-3Y
BV	33YHHH
DB	●
DNV	4Y40H5
LRS	33YH5
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1.4	0.3	≤ 0.025	≤ 0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)
				-50 °C
As Welded	≥ 420	530-640	≥ 22	≥ 47

Materials

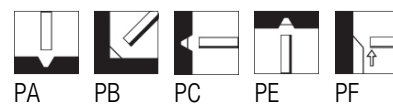
S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation.
 HD = 5: Re-dry at 340-360 °C for 2 hours, 5 times max.
 HD = 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		DRYF	
				PC	Code	PC	Code
2.5	350	70-95	21.4	185	●	28	●
3.2	350	95-130	35.4	115	●	22	●
3.2	450	95-130	46.0	55	●	22	●
4.0	450	130-180	65.0	85	●	18	●
5.0	450	170-230	102.0	55	●		
6.0	450	220-300	154.8	40	●		