

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 5 3	E 4924-1 A	E7024-1	E4924-1

Characteristics and typical fields of application

Rutile covered high performance electrode with 160 % weld metal recovery. Little spatter; fine rippled weld pattern; good striking and restriking ability; self releasing slag.

Well suited for thin fillet welds.

Base materials

S235JRG2 - S355J2;

Boiler steels P235GH/P265GH/P295GH/P355GH

Fine grained structural steels up to P355N- and M-grades;

Shipbuilding steels acc. A - E-grades, AH 32 - DH 36; ASTM

A36 Gr. all; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A366; A570 Gr. 30, 33, 36, 40, 45; A607 Gr. 45; A668 Gr. A, B;

A907 Gr. 30, 33, 36, 40; A935 Gr. 45; A936 Gr. 50

Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.07	0.35	0.65

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
				+20 °C	±0 °C
MPa	MPa	%	+20 °C	±0 °C	
aw	420	510	22	80	47
sr	410	470	26	85	

Operating data

	Polarity: DC (-) / AC	ø (mm)	L mm	Amps A
		3.2	450	120 – 160
		4.0	450	160 – 230
		5.0	450	250 – 340
		6.0	450	300 – 400

Approvals

TÜV (00349), DB (10.132.09) ABS, GL, BV, DNV, LR, CE