

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1M	AWS A5.1 / SFA-5.1
E 42 2 RA 5 3	E4924-1 A	E4924-1	E7024-1

Characteristics and typical fields of application

Rutile acid coated high performance electrode with roughly 160% weld metal recovery. Particularly high deposition rate; outstanding welding characteristics on alternating current; the weld metal exhibits good runout qualities also in tight corners. High radiographic soundness. Useable for gravity and auto contact welding; unproblematic for welding rusty and primer-coated plates.

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

Typical analysis

	C	Si	Mn
wt.-%	0.08	0.3	0.9


Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-20°C
u	430 (≥ 420)	520 (≥ 510)	22 (≥ 20)	80	55 (≥ 47)
s	420	500	27	80	

u untreated, as welded

s stress released, 600 °C / 2 h / oven down to 300 °C / air

Operating data

	Polarity	DC- / AC	Dimension mm	Current A
	Electrode identification	FOX Red AR 160 / E 42 2 RA / E7024-1	3.2 × 450	120 – 160
			4.0 × 450	160 – 240
			5.0 × 450	250 – 350
			6.0 × 450	300 – 400

Approvals

TÜV (00535), DB (10.014.84), ABS, BV, DNV, LR, CE