

## Classifications

| EN ISO 2560-A | EN ISO 2560-B | AWS A5.1 / SFA-5.1 | AWS A5.1M |
|---------------|---------------|--------------------|-----------|
| E 42 0 RR 5 3 | E 4924-1 A    | E7024-1            | E4924-1   |

## Characteristics and typical fields of application

Rutile coated high performance electrode with 160% weld metal recovery. Low 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

|       | C    | Si   | Mn   |
|-------|------|------|------|
| wt.-% | 0.07 | 0.35 | 0.65 |

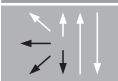
## Mechanical properties of all-weld metal - typical values (min. values)

| 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                     | 0°C |
| u         | 420                       | 510                    | 22                          | 80                       | 47  |
| s         | 410                       | 470                    | 26                          | 85                       |     |

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 R 160 / E 42 0 RR / E7024-1 |              | 3.2 × 450 | 120 – 160 |
|  |                          |                                     |              | 4.0 × 450 | 160 – 230 |
|  |                          |                                     |              | 5.0 × 450 | 250 – 340 |
|  |                          |                                     |              | 6.0 × 450 | 300 – 400 |

## Approvals

TÜV (00349), DB (10.014.53) ABS, BV, DNV, LR, CE