

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 7 3	E 4924 A	E7024	E4924

Characteristics and typical fields of application

Rutile covered high performance electrode with 180 % weld metal recovery.

High deposition rate; good strike and restrike ability; low spatter; partly self releasing slag; finely rippled weld pattern.

Preferred for fillet welds. Useable for shipbuilding, mechanical and structural engineering.

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	0.33	0.70

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
aw	420	510	22	70	47

Operating data

	Polarity: DC (-) / AC	ø (mm)	L mm	Amps A
		3.2	450	120 – 180
		4.0	450	180 – 220
		5.0	450	250 – 330
		6.0	450	280 – 450

Approvals

TÜV (01598), DB (10.132.07), ABS, BV, GL, LR, DNV, CE