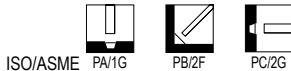


**Ferrod® 160T****CLASSIFICATION**

AWS A5.1 : E7024  
 ISO 2560-A : E 42 0 RR 73

**GENERAL DESCRIPTION**

Rutile electrode for fillet welds and horizontal V- and X-welds  
 Very high welding speed  
 Smooth weld appearance, very good slag release  
 High recovery (160% for 3.2 and 4.0 mm electrodes, and 180% for 5.0 mm electrodes)

**WELDING POSITIONS**

ISO/ASME

PA/1G

PB/2F

PC/2G

**CURRENT TYPE**

AC / DC -

**APPROVALS**

ABS	BV	DNV	GL	LR	RMRS	TÜV
2Y	2Y	2Y	2Y	2Y	2Y	+

**CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL**

C	Mn	Si
0.07	0.9	0.6

**MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL**

Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1 ISO 2560-A	min. 400 min. 420	min. 483 500-640	min. 17 min. 20	not required min. 47
Typical values AW	450	570	26	70

**PACKAGING AND AVAILABLE SIZES**

	Diameter (mm)	3.2	4.0	5.0	6.0
	Length (mm)	450	450	450	450
Unit: carton box	Pieces / unit	85	60	35	30
	Net weight/unit (kg)	6.4	6.3	5.8	6.5

Identification Imprint: 7024/FERROD 160T

Tip Color: none

Ferrod® 160T: rev. EN 24

**Ferrod® 160T****MATERIALS TO BE WELDED**

Steel grades/Code	Type
<b>General structural steels</b>	
EN 10025	S185, S235, S275, S355
<b>Ship plates</b>	
ASTM A 131	Grade A, B, D, AH32 to DH36
<b>Cast steels</b>	
EN 10013-2	G P 240R
<b>Boiler &amp; pressure vessel steel</b>	
EN 10028-2	P235, P265, P295, P355
<b>Fine grained steels</b>	
EN 10025 part 3	S275, S355
EN 10025 part 4	S275, S355

**CALCULATION DATA**

Sizes		Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weld- metal B	kg electrodes/ kg weldmetal 1/N
Diam. x length (mm)	Current range (A)							
3.2x450	130-160	AC						
4.0x350	180-220	AC	90	554	2.6	92.7	15	1.43
5.0x450	280-300	AC	78	897	5.4	166.7	9	1.43

\*Stub end 35mm

**WELDING PARAMETERS, OPTIMUM FILL PASSES**

Diameter (mm)	Welding positions	
	PA/1G	PB/2F
3.2	150A	140A
4.0	210A	200A
5.0	300A	280A

**REMARKS / APPLICATION ADVICE**

High yield strength steels such as S355, L360, P355 and DH36 preheat according EN 1011-1