

Ferrod[®] 160T

CLASSIFICATION

AWS A5.1	E7024	A-Nr	1
ISO 2560-A	E 42 0 RR 7 3	F-Nr	1
		9606 FM	1

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 ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1 ISO 2560-A		min. 400 min. 420	min. 490 500-640	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
	Length (mm)	450	450	450
Carton + PE foil	Pieces / unit	85	60	40
	Net weight/unit (kg)	5.6	6.3	6.1

Identification Imprint: 7024/FERROD 160T Tip Color: none

Ferrod[®] 160T: rev. C-ENZ7-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to DH36
Cast steels	
EN 10013-2	GP240R
Boiler & pressure vessel steels	
EN 10028-2	P235, P265, P295, P355
Fine grained steels	
EN 10025 part 3	S275, S355
EN 10025 part 4	S275, S355

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time	Energy	Dep. rate	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
			- per electrode at max. current - (S)*	E(kJ)	H(kg/h)			
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, P355 and DH36 preheat according EN 1011-1