

# Ferrod<sup>®</sup> 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 <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1 ISO 2560-A Typical values	AW	min. 400 min. 420 450	min. 490 500-640 570	min. 17 min. 20 26	not required min. 47 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<sup>®</sup> 160T: rev. C-ENZ7-01/02/16

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## EXAMPLES OF 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	GP240R
<b>Boiler &amp; pressure vessel steels</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 Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
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