

Classifications

EN ISO 2560-A	AWS A5.1 / SFA-5.1
E 38 0 RR 74	E7024

Characteristics and typical fields of application

Rutile iron powder electrode yielding approx. 180 % metal recovery. Self-detaching slag, smooth welds free of undercuts. Excellent striking characteristics. Highly economical for multi-layer welding of heavy cross sections.

Base materials

Steels up to a yield strength of 380 N/mm² (52 ksi) S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, Ship building steels: A, B, D, (A 32, A 36, D 32, D 36 - nur GL) ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52

Typical analysis

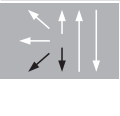
	C	Si	Mn
wt.-%	0.07	0.5	0.8

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

Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J	
			0°C	-10°C
440 (≥380)	510 (490 – 600)	27 (≥20)	85	65 (≥47)

u untreated, as welded

Operating data

	Polarity	DC- / AC	Dimension mm	Current A
	Electrode identification	FOX HL 180 Ti 7024 E 38 0 RR	3.2 × 450	120 - 180
			4.0 × 450	160 - 230
			5.0 × 450	200 - 330

Approvals

ABS, DNV, LR, CE