

Classifications

| EN ISO 2560-A | EN ISO 2560-B | AWS A5.1M | AWS A5.1 / SFA-5.1 |
|---------------|---------------|-----------|--------------------|
| E 42 0 RR 7 3 | E4924 A | E4924 | E7024 |

Characteristics and typical fields of application

Rutile coated high performance electrode with 180% weld metal recovery.
 High deposition rate; good strike and restrike ability; low spatter; 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

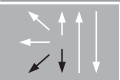
Typical analysis

| | C | Si | Mn |
|-------|------|------|------|
| wt.-% | 0.07 | 0.33 | 0.70 |

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

| Condition | Yield strength $R_{p0.2}$ | Tensile strength R_m | Elongation A ($L_0=5d_0$) | Impact energy ISO-V KV J | |
|-----------|---------------------------|------------------------|-----------------------------|--------------------------|-----|
| | MPa | MPa | % | 20°C | 0°C |
| u | 420 | 510 | 22 | 70 | 47 |

Operating data

|  | Polarity | DC - / AC | Dimension mm | Current A | |
|--|--------------------------|--------------------------------------|--------------|-----------|-----------|
| | Electrode identification | FOX Multifer 180 / E 42 0 RR / E7024 | | 3.2 × 450 | 120 – 180 |
| | | | | 4.0 × 450 | 180 – 220 |
| | | | | 5.0 × 450 | 250 – 330 |

Approvals

TÜV (01598), DB (10.014.97), ABS, BV LR, DNV, CE