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^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1		min. 400	min. 483	min. 17	not required
ISO 2560-A		min. 420	500-640	min. 20	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

LINCOLN ELECTRIC THE WELDING EXPERTS®

Ferrod® 160T

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	G P 240R
Boiler & pressure vessel steel	
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 (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weld-metal B	kg electrodes/ kg weldmetal 1/N
			- per electrode at max. current -					
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