

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1M	AWS A5.1 / SFA-5.1
E 42 2 RB 5 3	E4928 A	E4928	E7028

Characteristics and typical fields of application

Rutile-basic coated high performance electrode with ca. 160% weld metal recovery. Easy slag removal; fine rippled smooth welds; particularly good welding characteristics on primer-coated plates.

Base materials

S235JRG2 - S355J2;
Boiler steels P235GH/P265GH/P295GH;
Fine grained structural steels up to P355N- and M-grades;
Shipbuilding steels acc. A - E-grades, AH 32 to NVE 36

Typical analysis

	C	Si	Mn
wt.-%	0.08	0.4	0.85

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	-20°C
u	430 (≥ 420)	520 (≥ 510)	22 (≥ 20)	90	≥ 47
s	400	470	27	85	47

u untreated, as welded

s stress released, 600 °C / 2 h / oven down to 300 °C / air

Operating data

	Polarity	DC + / DC - / AC	Dimension mm	Current A
	Electrode identification	FOX Red BR 160 / E 42 2 RB / E7028	3.2 × 450	120 – 170
			4.0 × 450	180 – 230
			5.0 × 450	240 – 300
			6.0 × 450	290 – 390

Approvals

TÜV (01700), DB (10.014.85) ABS, BV LR, DNV, CE