

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 2 RA 5 3	E 4924-1 A	E7024-1	E4924-1

## Characteristics and typical fields of application

Rutile acid covered high performance electrode with roughly 160 % weld metal recovery.  
Particularly high deposition rate; outstanding welding characteristics on alternating current; the weld metal exhibits good runout qualities also in tight corners. High radiographic soundness.  
Useable for gravity and auto contact welding; unproblematic for welding rusty and primer-coated plates.

## 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

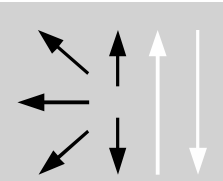
## Typical analysis of all-weld metal

	C	Si	Mn
wt.-%	0.08	0.28	0.75

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-20 °C
aw	420	510	22	75	50
sr	410	470	27	75	

## Operating data

	Polarity: DC ( + ) / AC	Ø mm	L mm	Amps A
		3.2	450	120 – 160
		4.0	450	160 – 240
		5.0	450	250 – 350
		6.0	450	300 – 400
		4.5	700	200 – 260
		5.0	700	230 – 300
		6.0	700	290 – 380

## Approvals

TÜV (00535), DB (10.132.29), ABS, BV, GL, LR, DNV, CE