

KESTRA Fe R 160

Stick electrode, unalloyed, rutile acid



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 (wt.-%)

C	Mn	Si
0.08	0.75	0.28

Mechanical properties of all-weld metal – typical values (minimum values)

Heat-treatment	Yield strength	Tensile strength	Elongation	Impact work	
	R _{p0.2}	R _m	A (L ₀ =5d ₀)	ISO-V KV J	
	MPa	MPa	%	20°C	-20°C
u	420	510	22	75	50
sr	410	470	27	75	

u: untreated, as welded

sr: stress relieved

Operating data

	Ø (mm)	Polarity:	L mm	Amps A
	3.2	DC (+) / AC	450	120 - 160
	4.0		450	160 - 240
	5.0		450	250 - 350
	6.0		450	280 - 450

Approvals

DNV • LR