KESTRA FeTi 160

Stick electrode, unalloyed, rutile

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 5 3	E 4924-1 A	E7024-1	E4924-1

Characteristics and typical fields of application

Rutile covered high performance electrode with 160 % weld metal recovery. Little spatter; fine rippled weld pattern; good striking and re-striking ability; self-releasing slag.
Well suited for thin fillet welds.

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 of all-weld metal (wt.-%)

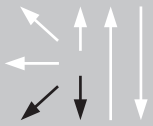
C	Mn	Si
0.07	**0.60**	**0.35**

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

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	0°C
u	**420**	**510**	**22**	**70**	**47**
sr	**410**	**470**	**26**	**70**	

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 - 230

Approvals

DNV • LR