

Classification

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 38 0 RR 7 4	E 4924 A	E7024	E4924

Characteristics and typical fields of application

Rutile iron powder electrode yielding approx. 180 % metal recovery. Self-detaching slag, smooth welds free of undercuts.

Excellent striking characteristics. Highly economical for multi-layer welding of heavy cross sections.

Base materials

Steels up to a yield strength of 380 N/mm² (52 ksi)

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, Ship building steels: A, B, D,(A 32, A 36, D 32, D 36 - nur GL)

ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52

Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt.-%	0.07	0.5	0.8

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	±0 °C	-10 °C
u	440 (≥ 380)	510 (490 – 600)	27 (≥ 20)	85	65 (≥ 47)	50

u untreated, as welded

Operating data

	Polarity:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (-)	FOX HL 180 Ti 7024	3.2	450	120 – 180
	AC	E 38 0 RR	4.0	450	160 – 230
			5.0	450	200 – 330

Approvals

ABS (2), DNV (2), GL (2Y), LR (2m), RINA (2), SEPROZ, RMR (2)