

Classifications

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

Characteristics and typical fields of application

Rutile covered high performance electrode with 160 % weld metal recovery. Low spatter; fine rippled weld pattern; good striking and re-striking ability; self-releasing slag.

Phoenix Rot R 160 S can be used in the vertical down position on inclines as great as 15°

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

	C	Si	Mn
wt.-%	0.07	0.35	0.65

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	
				+20 °C	±0 °C
aw	420	510	22	70	47
sr	410	470	26	70	

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	280 – 450

Approvals

TÜV (01495), ABS, DNV GL, BV, LR, CE