

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 0 RR 5 3	E 4914 A	E7014	E4914

Characteristics and typical fields of application

Rutile covered high performance electrode with 140 % weld metal recovery. Little spatter; self releasing slag; useable in diameters up to 4 mm for welding in the overhead and horizontal position; outstanding striking and restriking ability. 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

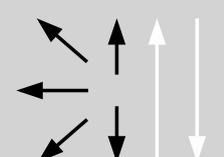
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn
wt-%	0.07	0.40	0.60

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	±0 °C
aw	420	510	22	70	47
sr	410	470	27	70	

Operating data

	Polarity: DC (–) / AC	ø (mm)	L mm	Amps A
		4.0	450	180 – 220
		5.0	450	240 – 320

Approvals

TÜV (00583), DB (10.132.28), ABS, BV, DNV, LR, GL, CE