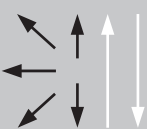


# KESTRA Fe R 160

## Prior Welding

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 <sub>p0.2</sub>	R <sub>m</sub>	A (L <sub>0</sub> =5d <sub>0</sub> )	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					