

# KESTRA FeTi 160

## Prior Welding

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

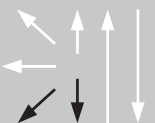
### Mechanical properties of all-weld metal – typical values (minimum values)

Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	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