



Selectarc 160

High efficiency
Rutile Electrode

Classification

AWS A5.1 : E7024

EN 499 : E 38 0 RR 5 3

ISO 2560-A : E 38 0 RR 5 3

Description & Applications

High efficiency rutile electrode (160%) with a high deposition rate. Applied for long beads and when a nice aspect of the weld seams is searched. Soft fusion and self releasing slag. Frequently used for butt-welding plates with a heavy thickness and for fillet welds.

Base materials

Construction steels for general use, Tube steels, Ship steels

EN- Designation	S185 – S355	L210 – L360
	P235 – P355	
Ship steels	Quality A and B	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.45	0.6	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>400	510-580	>22	+20°C >64 0°C >47

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x450	4,0x450	5,0x450
Current	(A)	150	200	260

ind.12



= -	~ 40V
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