Ferrod® 135T

CLASSIFICATION

AWS A5.1	E7024	**A-Nr**	1
ISO 2560-A	E 38 0 RR 5 3	**F-Nr**	1
		9606 FM	1

GENERAL DESCRIPTION

Rutile electrode for fillet welds and horizontal V- and X-welds
High welding speed
Smooth weld appearance
Self releasing slag
High recovery (140%)

WELDING POSITIONS (ISO/ASME)

PA/1G **PB/2F** **PC/2G**

CURRENT TYPE

AC / DC -

APPROVALS

ABS	BV	DNV	GL	LR	RMRS	TÜV
2Y	2Y	2Y	2Y	2Y	2Y	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si
0.08	0.5	0.35

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) 0°C
Required: AWS A5.1		min. 400	min. 490	min. 17	not required
ISO 2560-A		min. 380	470-600	min. 20	47
Typical values	AW	460	530	25	54

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	3.2	4.0	5.0
	Length (mm)	450	450	450
Carton + PE foil	**Pieces / unit**	90	65	45
	Net weight/unit (kg)	5.5	5.7	5.9

Identification Imprint: 7024-FERROD 135T Tip Color: none

Ferrod® 135T: rev. C-EN26-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275,S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to DH36
Cast steels	
EN 10013-2	GP240R
Boiler & pressure vessel steels	
EN 10028-2	P235, P265, P295, P355
Fine grained steels	
EN 10025 part 3	S275, S355
EN 10025 part 4	S275, S355

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
			- per electrode at max. current -					
3.2x450	130-150	AC	85	344	1.6	61.3	27	1.67
4.0x450	180-200	AC	92	515	2.2	87.7	18	1.67
5.0x450	275-300	AC	86	735	3.7	129.9	11	1.43

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PA/1G	PB/2F	PC/2G
3.2	150A	140A	140A
4.0	200A	190A	190A
5.0	290A	280A	

REMARKS / APPLICATION ADVICE

High yield strength steels such as S355, P355 and DH36 preheat according EN 1011-1