

Ferrod 200T

High recovery rutile electrode

Classification

AWS A5.1-91 : E7024
EN 499-94 : E 42 2 RR 74

General description

Rutile electrode for fillet welds and filling

200% recovery

Very high welding speed, low spatter

Smooth weld appearance

Self releasing slag

Easy start and restart

Electrode can be used with drag or contact welding technique

Welding positions



ISO/ASME PA/1G PB/2F

Current type

AC / DC electr. +

Approvals

DNV

3

Chemical composition (w%), typical, all weld metal

C	Mn	Si
0.06	1.1	0.5

Mechanical properties, all weld metal

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -20°C
Required: AWS A5.1-91		min. 399	min. 482	min. 17	not required
EN 499-94		min. 420	500 – 640	min. 20	min. 47
Typical values	AW	520	550	23	60

Packaging, available sizes and identification

	Diameter (mm)	4.0	4.0	4.5	4.5
	Length (mm)	450	600	450	600
Unit: Box	Pieces / unit (nominal)	55	54	44	44
	Net weight/unit (kg)	6.1	8.0	6.1	8.0

Identification Imprint: 7024/Ferrod 200T

Tip colour: yellow

Ferrod 200T: rev. EN 15

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Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH36
Boiler & pressure vessel steel	EN 10028-2	P235, P265, P295, P355
Fine grained steel	EN 10113-2 EN 10113-3	S275, S355, S275, S355

Calculation data

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (s)*	Energy E(kJ)	Dep.rate H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
4.0 x 450	170 - 210	DC+	73	621	3.7	110.5	14	
4.0 x 600	170 - 210	DC+	114	752	3.3	148	10	
4.5 x 450	240 - 270	DC+	74	808	4.6	145.6	11	
4.5 x 600	240 - 270	DC+	132	1001	3.6	183.9	8	

*stub end 35 mm

Application advice

High yield strength steels such as S355, L360, P355 and X60 preheat according EN 1011-1