merian®

Böhler WELDING

EN ISO 2560-A:2005:	E 38 0 RR 74
EN ISO 2560-B:2005:	E 49 24 A
AWS A5.1-04:	E7024
AWS A5.1M-04:	E4924

BÖHLER FOX HL 180 Ti

SMAW rutile electrode, mild steel, high efficiency

Description

Rutile iron powder electrode yielding approx. 180% metal recovery. Self-detaching slag, smooth welds free of undercuts.
Excellent striking characteristics. Highly economical for multi-layer welding of heavy cross sections.

Typical Composition of All-weld Metal

	C	Si	Mn
wt-%	**0.07**	**0.5**	**0.8**

Mechanical Properties of All-weld Metal

		u	
yield strength R_e N/mm^2 (MPa):		**440**	(≥400)
tensile strength R_m N/mm^2 (MPa):		**510**	(490-600)
elongation A (L_0=5d_0) %:		**27**	(≥22)
impact work ISO-V KV J	+20°C:	**85**	(≥60)
	±0°C:	**65**	(≥47)
	-10°C:	**50**	

u untreated, as-welded

Operating Data

re-drying: not necessary

electrode identification:
FOX HL 180 Ti 7024 E 38 0 RR

ø mm	L mm	amps A
3.2	450	120-180
4.0	450	160-230
5.0	450	200-330

Base Materials

steels up to a yield strength of 380 N/mm^2 (52 ksi)

S235JR, S275JR, S235J0G3, S275J0G3, S355J0G3, P235GH, P265GH, S255N, P295GH, S235JRS1 - S235J0S1, S235JRS2 - S235J0S2

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

Approvals and Certificates

TÜV-A (17), ABS (2), DNV (2), GL (2Y), LR (2m), RINA (2), SEPROZ, ÖBB, RMR (2)