

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1M	AWS A5.1 / SFA-5.1
E 42 0 RR 5 3	E4914 A	E4914	E7014

Characteristics and typical fields of application

Rutile coated high performance electrode with 140% weld metal recovery. Little spatter; self releasing slag; useable in diameters up to 4 mm for welding in the overhead and horizontal position; outstanding striking and restriking ability. 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

	C	Si	Mn
wt.-%	0.07	0.40	0.60

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	0°C
u	420	510	22	70	47
s	410	470	27	70	

Operating data

	Polarity	DC – / AC	Dimension mm	Current A
	Electrode identification	FOX Multifer 130 / E 42 0 RR / E7014	4.0 × 450	180 – 220
			5.0 × 450	240 – 320

Approvals

TÜV (00583), DB (10.014.94), ABS, BV, DNV GL, LR CE