

ETC PH24 FERROMATIC 160



MMA Electrodes C-Mn and low-alloy steels

FERROMATIC 160 is a thick rutile coated high-efficiency MMA electrode with a recovery of ~160% for welding butt and fillet joints. Used for the cost effective filling of thicker weld sections and the welding of long fillet welds. Easy striking and restriking, low spatter and mostly self-releasing slag. The weld bead is very smooth and clean with well blended toes, without undercut into the base plate. For applications requiring higher levels of sub zero ISO-V toughness, basic coated FEBAMATIC 160S is recommended.

Classification	
EN ISO	2560-A: E 42 0 RR 73
EN	499: E 42 0 RR 73
AWS	A5.1: E 7024

Approvals	Grade
ABS	2
BV	2Y
DB	●
DNV	2
GL	2
LRS	2m
RINA	2
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.1	0.9	0.45

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	0 °C
As Welded	≥ 420	510-610	≥ 22	≥ 60	≥ 47

Materials

S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

Current condition and welding position

AC; DC-; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
2.5	350	90-115	34.8	115	ETC PH2425
3.2	450	105-140	71.1	76	ETC PH2432
4.0	450	160-220	107.8	51	ETC PH2440
5.0	450	240-320	148.1	39	ETC PH2450

