FERROMATIC 160

OERLIKON

MMA Electrodes
C-Mn and low-alloy steels

FERROMATIC 160 is a thick rutile coated high-efficiency MMA electrode. The addition of iron powder and ferroalloys leads to a recovery of~160 % allowing longer or wider beads to be welded in one run with increased welding speed. Welding of butt and fillet joints.
Applications in shipbuilding, general metal construction and in the construction of tanks, containers and boilers in downhand position.
Easy striking and restriking, low spatter loss and self-releasing slag. The weld bead is smooth with well blended toes, without undercut into the base plate. Can be welded in "touch" technique. AC welding requires equipment with OCV of min. 60 V. For applications needing higher levels of sub-zero ISO-V toughness, basic coated FEBAMATIC 160S is recommended.

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

Approvals	Grade
ABS	2
BV	2Y
DB	●
DNV	2

Approvals	Grade
GL	2
LRS	2Ym
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 100º-110ºC for 1 hour, max. 3 times.

Current condition and welding position
AC; DC-; DC+
 PA PB

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
3.2	450	105-140	71.05	76	W000287242
4.0	450	160-220	107.84	51	W000287243
5.0	450	240-320	148.72	39	W000287244