



# Selectarc 180

High efficiency  
Rutile Electrode

## Classification

AWS A5.1 : E7024

EN 499 : E 42 0 RR 7 4

ISO 2560-A : E 42 0 RR 7 4

## Description & Applications

High efficiency rutile electrode (180%) with a high deposition rate. Applied for long beads and when a nice aspect of the weld seams is searched. Soft fusion and self releasing slag. Frequently used for butt-welding plates with a heavy thickness and for fillet welds.

## Base materials

### Construction steels for general use, Tube steels, Ship steels

EN- Designation	S185 – S355 P235 – P355	L210 – L360
Ship steels	Quality A and B	
ASTM	A285 grade C A442 grade 55, 60	A414 grade C, D, E, F A515 grade 55, 60, 65

## Typical Weld Metal Composition ( % )

C	Si	Mn	P	S	Fe
<0.10	0.6	1.0	<0.025	<0.025	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>420	510-580	>22	+20°C >64 0°C >47

## Welding Current & Instructions

Electrode	ØxL ( mm )	3,2x450	4,0x450	5,0x450
Current	( A )	150	200	260

ind.12



= - ~ 40V



**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.