



HILCO REGINA 160

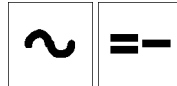
Stick electrodes – unalloyed steel – high efficiency

AWS A5.1: E 7024-1

EN ISO 2560-A: E 42 0 RR 53

Coating type:
Rutile

Current:



Welding positions:



Regina 160 is our easy-to-handle high efficiency (recovery 160%) electrode for making fillet welds in the flat and horizontal position. This electrode has a smooth quiet arc, very low spatter and easily removable slag. Regina 160 can be used with high travel speeds, resulting in high deposition rates (> 3,5 kgs./hour). Typical applications include joining mild and low-alloyed structural steels as well as usage on primer painted or contaminated plates. Regina 160 is an all-current type (AC/DC).

Base materials to be welded:

- Ships plate A-D, A(H)32-D(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2, St.33-St.52, C(K)10-C(K)35
- Boiler steel P235GH-P295GH, HI, HII, 17Mn4
- Fine grain steel P275N-P355N, S275N-S355M, StE285-StE 355, StE285-StE355TM
- Pipe steel P235T1-P355N, L210-L360NB, St37.0-St52, St45.8, X42-X52, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P
0,09	0,7	0,4	0,009	0,018

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 510	≥ 22	0°C ≥ 47 20°C ≥ 47

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	450	65,6	120-160
4,0	450	103,6	160-230
5,0	450	154,3	250-340