



HILCO REGINA 150

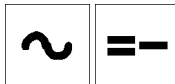
Stick electrodes – unalloyed steel – high efficiency

AWS A5.1: E 7024-1

EN ISO 2560-A: E 42 2 RA 53

Coating type:
Rutile-acid

Current:



Welding positions:



Regina 150 is our rutile-acid coated high efficiency (recovery 160%) electrode for making x-ray quality fillet welds in the flat and horizontal position. This electrode has a smooth quiet arc, very low spatter and easily removable slag (self-releasing even in narrow angles). Regina 150 can be used with high travel speeds, resulting in high deposition rates (> 3,6 kgs./hour). Typical applications include joining heavier sections of mild and low-alloyed structural steels found in shipbuilding and general constructions as well as usage on primer painted or contaminated plates.

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-ESStE355, StE285TM-ESStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, 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
0,10	0,90	0,3	0,008	0,015

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	-20°C ≥ 50 20°C ≥ 75

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
4,0	450	96,7	170-240
5,0	450	147,5	230-340