

7024 (150)

CATEGORY	SMAW Stick Electrodes
TYPE	High efficiency, rutile electrode with approximately 150% metal recovery
APPLICATIONS	Wagon building, shipbuilding, general construction, vessel, containers
PROPERTIES	The 7024 is a high performance electrode with a thick rutile coating and a recovery of 150%. For joining and surfacing in mechanical engineering, body and wagon building as well as in the fabrication of vessels and containers and in shipbuilding. Moreover this electrode can be used for all kinds of steel constructions. The 7024 has a high current carrying capacity and good striking properties. This electrode is very economical thanks to low spattering losses and easy slag removal.

CLASSIFICATION	AWS	A 5.1: E 7024
	EN ISO	2560-A: E 38 0 RR 53
	DIN	1913: E 43 32 RR11 150

SUITABLE FOR	Steel types:	DIN:	W.Nr:
	Unalloyed steels	St 33 to St 52.3	1.0035, to 1.0570
	Boiler steels	HI, HII, 17Mn4	1.0345, 1.0425
	Finegrained steels	StE 255 to StE 355	1.0481, 1.0475
	Shipbuilding plates	A, B, D	1.0461 to 1.0562
	Steel castings	GS-38 to GS-52	1.0440, 1.0472
	-	-	1.0416 to 1.0551

APPROVALS	CE approved
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WELDING POSITIONS:	
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C	Mn	Si	Cr	Ni	Mo
0.08	0.55	0.25	-	-	-

MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	0°C	Impact Energy (J) ISO-V		Hardness HRC / HV
AW	>390	470-540	>22	>47	-40°C	-60°C	

AW: as welded

WELDING PARAMETERS PACKING					
Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) AC/DC-	kg / can	kg / 6pack	kg / 1000
3,2	350	120-160	2,5	15	50
4,0	450	160-200	3.1	18.6	100
5,0	450	220-260	3.0	18	147

REDRYING TEMPERATURE	250°C / 1 hr
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