

7024 (200)

CATEGORY SMAW Stick Electrodes

TYPE High efficiency, rutile electrode with approximately 200% metal recovery.

APPLICATIONS Wagon building, shipbuilding, general construction, vessel, containers.

PROPERTIES The 7024-200 is a high performance electrode with a thick rutile coating and a recovery of 200%. 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 7024-200 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 42 0 RR 74 2560-B: E 49 24 A
DIN	1913: E 51 22 RR 11 200

SUITABLE FOR

Steel types:	DIN:	W.Nr:
Unalloyed steels	St 33 to St 52.3	1.0035, to 1.0570
Boiler steels	HI, HI1,17Mn4	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

WELDING POSITIONS:

C	Mn	Si	Cr	Ni	Mo
0.08	0.75	0.30	-	-	-

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
					-40°C	-60°C	
AW	>430	490-550	>22	>47			

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	450	130-180			72.5
4.0	450	180-220			113
5.0	450	240-290	3.2	19.2	157.6
6.0	450	300-370			260

REDRYING TEMPERATURE 250°C / 1 hr.