

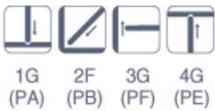
## E7024

AWS A5.1 E7024  
EN ISO 2560-A E42 0 RR 7 4  
GB/T5117 E5024

### Description:

A rutile, iron powder and gravity type electrode with high welding efficiency (180%). Flat and flat fillet welding on carbon steel and low alloy steel. AC & DC+

### Welding Position:



### Diameters:

3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	570
Yield strength(MPa):	502
Elongation (%):	27
Impact values( $\geq 47/0^{\circ}\text{C}$ ):	75

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.067	0.75	0.023	0.016	0.43	0.008	0.026	0.005	0.016

### Welding Current:(AC/DC+)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	-	120-150	160-200	220-250

### Note:

- 1.The electrodes must be baked 1-2 hours in  $350^{\circ}\text{C}$ - $450^{\circ}\text{C}$  before using.
2. Rusty, oil stains, water and other impurity on the weld parts should be cleaned before welding.