

S-7024.F

Type : High recovery Rutile

Conformances

AWS A5.1/ ASME SFA5.1 E7024
 JIS Z3211 E4924
 EN ISO 2560-A-E42 0 RR 7 4
 ABS 2
 LR 2, 2Y, 2YG
 DNV 2 (25 t)
 NK KMW2, KMW52
 CWB CSA W48 E4924

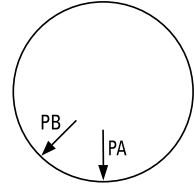
Applications

- Heavy steel fabrication
- Shipbuilding

Features

- Highly efficient fillet welding
- High welding speed
- Good bead appearance
- Easy to remove slag

Welding Position



Current

AC or DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
3.2 (1/8)	400 (16)	✓	
4.0 (5/32)	450 (18)	✓	
4.5(11/64)	450 (18)	✓	
4.5(11/64)	700 (28)	✓	
5.0 (3/16)	450 (18)	✓	
5.0 (3/16)	700 (28)	✓	
6.0 (15/64)	450 (18)	✓	
6.0 (15/64)	700 (28)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.08	0.42	0.82	0.022	0.014

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
513 (74,400)	561 (81,400)	23.4	0 (32)	61 (45)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	4.5 (11/64)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	400 (16)	450 (18)	450 (18) 700 (28)	450 (18) 700 (28)	450 (18) 700 (28)
F	100~150	140~200	180~230	200~250	260~300

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX