

# S-7024.F

TYPE : High recovery Rutile

AWS A5.1 / ASME SFA5.1 E7024

JIS Z3211 E4924

EN ISO 2560-A - E42 0 RR 7 4

## Applications

S-7024.F can be used for welding of flat and horizontal fillet welding of internal structures, inside hulls, building, machine construction.

## Characteristics on Usage

S-7024.F is a representative powder titania type electrode widely used for flat and horizontal fillet welding. This is an excellent electrode with extremely high efficiency.

## Notes on Usage

- ① The optimum speed ratio is 1~1.5%.
- ② Usability degrades when moistened. In case of absorbing moisture, it must be dried.  
[70~100°C(158~212°F), 30~60minutes]

## Welding Position



1G 2F  
(PA) (PB)

## Current

AC or DC ±

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

## Approval

ABS, LR, DNV, NK, CWB

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

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