



S-7024.F

AWS A5.1 / ASME SFA5.1 E7024
JIS Z3211 D4324

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

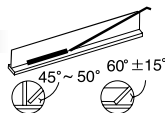


1G

2F

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

Y.S N/mm ² (lbs/in ²)	T.S N/mm ² (lbs/in ²)	EL. (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
495 (71,900)	569 (82,600)	27.8	0 (32)	48 (36)

Approval

ABS, LR, DNV, NK, CWB

Packing

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

Size 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)	450 (18)	450 (18)
			700 (28)	700 (28)	700 (28)
F	100~150	140~200	180~230	200~250	260~300