

# SC 7024

Mild steel electrode

## Classification

AWS A 5.1 : E 7024

EN 499 : E 42 0 RR 53

ISO 2560-A : E 42 0 RR 53

## Description and applications

High efficiency, Iron powder electrode designed for outstanding deposition rates. Deposition efficiency is approximately 140–150 % .Excellent arc stability, soft fusion, fine ripples, self releasing slag, very low spatter. Applied for heavy steel structures, storage tanks, bridge girders, fabrication of earth moving equipments, pressure vessels etc. Frequently used for butt-welding plates with a heavy thickness and for fillet welds.

## Base materials

### Construction steels for general use, tube steels, ship steels

<b>EN- Designation:</b>	S185-S355	L210 - L360
	P235-P355	
<b>Ship steels:</b>	Quality A and B	
<b>ASTM:</b>	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

## All weld metal mechanical properties (typical)

Yield strength Rm (N/mm <sup>2</sup> )	Tensile strength Rm (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy impact value ISO-V (J) +20°C
>400	510-600	24	>64

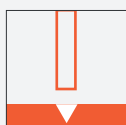
## Typical weld metal chemical composition (%)

C	Si	Mn	S	P
0.10	0.40	0.90	0.020	0.025

## Current conditions

Diameter (mm)	Length (mm)	Current (A)
3.15	350 & 450	120-150
4.00	450	150-190
5.00	450	180-230

## Welding instruction



PA



PB