

Brand Name & Classification

AWS/ASME SFA-5.4: E7024
DIN 1913: E 51 32 RR 11 160
EN 499: E 38 0 RR 73

Properties

High efficiency electrode having a weld metal recovery of approx 170 %. Preferably used for fillet welds. Smooth welds blending into base metal without undercut. Slag self releasing

Application

Unalloyed structural steel: St33 to St52-3
Boiler plates: HI, HII, 17Mn4
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355
Shipbuilding steels: A, B, D, E, AH 32 to EH 36
Cast steel: GS-38 to GS-52

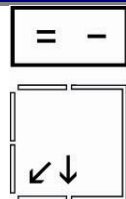
**Weld Metal Analysis
Typical values**

Carbon: 0.08
Silicon: 0.40
Manganese: 0.90

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM2	500 – 640 N/mm2	> 24 %	150 J at +20 c 120 J at -20 c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400/450	90-140
4.0	400/450	140-190
5.0	400/450	190-250