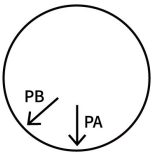


S-7024.F

Classification

- AWS** A5.1/ASME SFA-5.1 E7024
- JIS** Z 3211 E4924
- EN** ISO 2560-A E42 0 RR 7 4
- KS** D7004 E4324

Welding Positions



Features

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

Polarity

AC or DC ±

Application Areas

- Heavy steel fabrication
- Shipbuilding

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	DNV	LR	NK	CWB
✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.37	0.69	0.021	0.009

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
477(69)	556(81)	24	0(32)	61(45)

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
3.2(1/8)	400 (16)	100-150	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.0(5/32)	450 (18)	140-200	
4.5(11/64)	450 (18)/700 (28)	180-230	
5.0(3/16)	450 (18)/700 (28)	200-250	
6.0(15/64)	450 (18)/700 (28)	260-300	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux