

Classifications

EN ISO 2560-A:2006	: E 42 A RR 53	KS D 7004	: E4324
EN ISO 2560-B:2006	: E 49 24 A	JIS Z 3211	: E4924
AWS A5.1-04	: E7024		

Description

- Covering is iron powder, titania type for flat and horizontal fillet welding of ship structure, bridges, structural steels for buildings and general structures.
- Designed for high efficiency in single pass.
- Excellent slag removal and good bead appearance.
- Redry the electrode at 120~150°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.08	0.35	0.78	0.020	0.014	0.02	0.03	0.01	0.01	0.85

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				RT	0°C	
AWS A5.1	min. 400	min. 490	min. 17			
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	480	570	28	65	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +, -)

Dia.	(mm)	3.2	4.0	4.5	5.0	5.5	6.0
		400	450	450	450	450	450
Length	(mm)		550	550	550	550	550
				700	700	700	700
Amp. (A)	F H-Fillet	100~150	140~190	180~230	200~250	230~270	260~300

Approvals

ABS	BV	DNV	GL	KR	LR	NK
2Y,E7024	2Y	3	2Y	2Y	2Ym	KMW52

* Others : JIS, CWB, CE