

# K-7024

For 490MPa high tensile steel

## Classifications

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

## Approvals

ABS	: 2Y, E7024
BV	: 2Y
DNV	: 2Y
LR	: 2Ym No
NK	: KMW52
Other	: JIS, CWB, CE

## 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

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)		Remarks
	(MPa)	(MPa)	(%)	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 +/-)

Diameter	(mm)	3.2	4.0	4.5	5.0	5.5	6.0
Length	(mm)	400	450	450	450	450	450
Amperage	F	100-150	140-190	180-230	200-250	230-270	260-300
	H-Fillet						