

# K-7024

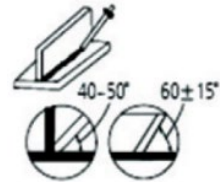
For 490MPa high tensile steel

## 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 +/- )

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

## Approvals

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

\*Others: JIS, CWB, CE