

FOR HIGH TENSILE
STRENGTH STEEL

AWS E7024
JIS D4324
KS E4324

K-7024

Typical applications

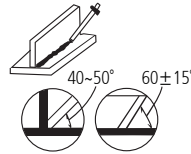
Flat and horizontal fillet welding of ship structures, bridges, structural steels for buildings and general structures.

Coating

Iron powder, titania type.

Characteristics on Usage

- ① Designed for high efficiency in single pass.
- ② Quiet and stable arc.
- ③ Good bead appearance.
- ④ Easy slag removal, mostly self-releasing.
- ⑤ Excessive moisture absorption causes undercut and irregular beads.
- ⑥ Redry the electrode at 100~130°C for 30~60 minutes prior to use.



Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.08	0.35	0.78	0.016	0.012

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (0°C)
480 {49}	570 {58}	28	70 {7}

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.	F	100~150	140~190	180~230	200~250	230~270	260~300
	H-Fil						

Welding positions



Approved by

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS