

AK E7024

Description: A rutile, iron powder, and gravity type electrode for high welding efficiency of fillets in the horizontal vertical position, with 180% recovery. AC or DC+ connection, with excellent welding operation properties like a stable arc and easy arc restrike.

Application: Flat and flat fillet welding on carbon steel and low alloy steel.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.15	0.9	1.25	0.035	0.035	0.30	0.30	0.20	0.08
Actual Result	0.067	0.43	0.75	0.016	0.023	0.008	0.005	0.026	0.016

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	490-660	≥400	≥ 22	≥47J(0℃)
Actual Result	520	430	27	75

Recommended welding parameters:

Diameter / mm		2.5	3.2	4.0
Welding current / A	F/ H	---	120-150	220-250
	V/OH	---	---	---