

CLASSIFICATION

EN ISO 2560-A : E 46 0 RR 74
AWS A5.1 : E7024

GENERAL DESCRIPTION

L-7024 is a heavily coated, high efficiency rutile iron powder electrode. It gives a metal recovery of about 165 % due to high iron powder content in its coating. It is particularly suitable for fillet welding of thick plates. It gives smooth weld bead appearance with a soft arc. The slag is easy to remove.

APPROVALS

CE, GOST, SEPRO, TSE

ABS	BV	RINA	TL
2	2	2	2

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.08	0.40	0.70

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 500 N/mm ²
Tensile Strength	: 580 N/mm ²
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 60 J (0°C)

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 70 V ; DC (-)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
3.25	450	130 - 155	6540	5.9 / 90	6
4.00	450	170 - 240	10050	6.0 / 60	6
5.00	450	250 - 310	14920	6.0 / 40	6



APPLICATIONS AND MATERIALS TO BE WELDED

It is used for the welding of medium carbon and mild steels. AS DT-165 is an ideal electrode particularly used for welding vertical- horizontal fillets. Weld metal goes well up the vertical plate giving a good transition to the base metal without undercutting, even at high currents.

Machinery fabrication and ship building where smooth weld beads are required; boiler and pressure vessel manufacturing; automotive bodies and steel and bridge constructions are among some application areas where AS DT-165 is extensively used as it brings high efficiency in terms of welding cost.

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52* C 10 - C 22	S185, S235, S275, S355 C10 - C22
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 420	S255N - S420N P255NH - P420NH
Pipe Materials	StE 210-7 - StE 360-7 X42, X46, X52, X60 (API 5LX)	L210 - L360NB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII, HIII	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D*, E* AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52*	GE200, GE240, GE260

(* It is recommended to use a basic coated electrode in the root pass.

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

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