

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 180 % due to high iron powder content in its coating. It is particularly suitable for GRAVITY WELDING of thick plates. It gives smooth weld bead appearance with a soft arc. The slag is easy to remove. As the electrode length is 700 mm, it enables uninterrupted welding with large and long welding beads.

APPROVALS

CE, GOST, SEPRO, TSE

ABS	BV	DNV	LRS	TL
2	2	2	2m	2

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

C	Si	Mn
0.08	0.45	0.90

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 500 N/mm ²
Tensile Strength	: 560 N/mm ²
Elongation (L=5d)	: 25 %
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]
4.00	700	180 - 230	16900	10.1 / 60
5.00	700	240 - 270	25530	10.2 / 40



APPLICATIONS AND MATERIALS TO BE WELDED

It is used for the welding of mild steels having a maximum tensile strength of 440 N/mm² and for ordinary ship's plate of A- and D- quality. L-7024 is an ideal electrode particularly used for fillet and butt joints in flat and horizontal positions. 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 L-7024 is extensively used. It brings high efficiency as it is a very fast electrode with a very high deposition rate.

	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 H1, H11, H111	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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