

Key Features

- ▶ Iron powder rutile based with 165% recovery
- ▶ Good start and restart capability, high deposition
- ▶ Reliable X-ray soundness
- ▶ Excellent bead appearance

Typical Applications

- ▶ Ideal for many medium to large fabrication jobs
- ▶ Low spatter and low penetration applications

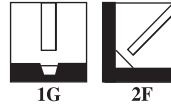
Conformances

AWS A5.1/A5.1M	E7024 / E4924
AS/NZS 4855-B	E4924A
ABS / DNV	Grade 3
LR	Grade 2

Diameter / Packaging

Diameter mm	Length mm	Outer Carton Weight 15kg
3.2	350	70243250
4.0	350	70244050
5.0	350	70245050

Welding Positions



Mechanical Properties - As Required per AWS A5.1 & AS/NZS 4855-B

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -29°C
Requirements - AWS	400 min	490 min	17 min	N/S
Requirements - AS/NZS	400 min	490 min	16 min	N/S
Typical Results - As Welded	460	525	30.5	55

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.045	0.83	0.42	0.026	0.018

Typical Operating Procedures

Polarity	Current (amps)		
	3.2 mm	4.0 mm	5.0 mm
AC / DC	100-150	170-220	220-290