

ROYAL - 724 (E 7024)

AWS : A 5.1, E 7024 IS : 814 ERR 5242XK EN ISO 2560 A E 42 0 RR 33

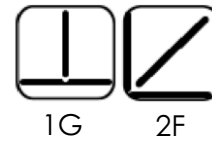
Applications

Welding of heavy structures & machinery parts. Crane, Bridge, Girders. Ship Building. Earthmoving equipment's, Pressure Vessels.

Characteristics on Usage

A heavy coated iron powder type electrode with a deposition efficiency of approximately 140%. It is touch welding electrode with high deposition rate for flat and horizontal position. The electrode is easy to manipulate and gives smooth arc with radiographic quality of welds. It can be used at high current and gives high welding productivity.

Welding Positions



Notes On Usage

- Optimum speed ratio is 1-1.5%.
- Usability degrades when moistened. In case of absorbing moisture, it must be dried. [70-100°C]

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.15 Max	1.25 Max	0.90 Max	0.035 Max	0.035 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT 0° C
490 Min	400 Min	22 % Min	47 Joules Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	80 – 120
3.15 x 450	5	20		130 – 170
4.00 x 450	5	20		180 – 240
5.00 x 450	5	20		250 – 290