Inweld 7024 High Deposition – Iron Powder

Alloy E7024
AWS A5.1 E7024

AC/DC +/- (reverse or straight polarity)

Description and Applications:

High speed rutile and iron powder coated electrode used for single pass welding on horizontal or flat fillet welds.
Thick flux coating gives this electrode greater deposition efficiency and a slightly convex to flat weld bead with a finely rippled appearance.
Quiet stable arc with low spatter and shallow penetration into the base metal.
A very easy to use electrode. The slag is heavy but peels off easily.
Commonly used on heavy construction and earth moving equipment, truck bodies, ships barges and railcars as well as many other mild steel and alloy steel applications.

Procedure:

Clean the weld area of all contaminants. If possible - bevel heavy sections to a 60 vee. AC or DC +/- (reverse or straight polarity) can be used. Set your amperage to the proper range for the size electrode you are using. A medium arc length of approximately 1/8" should be maintained. Hold the electrode at an angle 5-10 (off 90) in the direction of travel, staying ahead of the weld puddle. A straightforward progression is recommended. Do not use the weaving technique. Allow the weld deposit to air cool and remove slag with a chipping hammer. Brush to a nice finish.

Recommended Parameters	Diameter	Recommended Amperage (Flat only)
	3/32” (2.4mm)	60-100
	1/8“ (3.2mm)	120-170
	5/32“ (4.0mm)	140-190
	3/16“ (4.8mm)	200-250
	7/32” (5.6mm)	230-270
	1/4” (6.4mm)	280-380

Warning

- This product, when used for welding or cutting, produces fumes or gases which may contain chemicals known to the state of California to cause birth defects (or other reproductive harm), and in some cases cancer. (California Health & Safety Code 25249.5 et seq.)
- Read American National Standards Z49.1, "Safety in Welding Cutting and Allied Processes," from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.

Fumes and Gases can be hazardous to you health.

- Before use, read and understand the materials Material Safety Data Sheet (MSDS), the manufacturer's instructions and your employers safety practices.
- If MSDS is not enclosed, obtain one from your employer.
- Keep your head out of the fumes. See section 5 of the MSDS for specific fume concentration limits.
- Use enough ventilation exhaust at the arc or both to keep fumes and gases from your breathing zone and general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding. Electric Shock can kill.
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- ARC Rays can injure eyes and burn skin.
- Wear welding helmet with correct filter.
- Wear correct eye, ear and body protection.
- Welding can cause fire or explosion" Do not weld near flammable material.
- Watch for fire, keep extinguisher nearby.