

# Inweld 7024

AWS A5.1 E7024

## Chemical Composition of Inweld 7024

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.15	0.20	0.30	0.30	1.25	0.90	0.35	0.35	0.08	---

## 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.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	70,000 psi
Yield Strength:	58,000 psi
Elongation:	22%

## Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
1/8"		100-160
5/32"		160-215
3/16"		220-280
7/32"		270-340
1/4"		320-400

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