

Product Data Sheet

SUPER OPTIMAL 7024

Classification

AWS A 5.1: E 7024

EN 499: E 42 0 RR 53

ISO 2560-A: E 42 0 RR 53

Description and applications

High efficiency, Iron powder electrode designed for outstanding deposition rates. Deposition efficiency is approximately 140-150 %. Excellent arc stability, soft fusion, fine ripples, self releasing slag, very low spatter. Applied for heavy steel structures, storage tanks, bridge girders, fabrication of earth moving equipments, pressure vessels etc. Frequently used for butt-welding plates with a heavy thickness and for fillet welds.

Base materials

Construction steels for general use , Tube steels, Ship steels

EN- Designation:	S185 – S355	L210 – L360
	P235 – P355	
Ship steels:	Quality A and B	
ASTM:	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Typical weld metal Chemical Composition (%)

C	Si	Mn	S	P
0.10	0.40	0.90	0.020	0.025

All weld metal mechanical properties (typical)

Yield Strength R_p (N/mm ²)	Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J +20°C)
>400	510-600	24	>64

Amperes (A)

2.40mm	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	5.00mm
70-100	80-120	120-150	120-150	120-150	150-190	180-230

Welding position



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