

RATNA 7024

Extra heavy coated, Iron powder & rutile type welding Electrode for high deposition efficiency 140% Min.

CLASSIFICATION : AWS/SFA-5.1: E 7024, BS 639 E 5122RR14032
IS-814: ERR 5242 KX , DIN 1913 E 5122RR1135140

APPROVAL :

CHARACTERISTICS : An extra heavy coated, iron powder, rutile type electrodes for achieving high deposition efficiency 140% Min. Electrode is touch welding type, gives smooth arc, least spatter losses, reduces welding time and gives increased productivity and output by using high current. Welds are of radiographic quality.

APPLICATION :

- 1) heavy sections machinery components.
- 2) Heavy Structural's works like cranes and bridges.
- 3) Assembly of earthmoving equipments.
- 4) Welding heavy columns, locomotive.
- 5) Heavy machinery parts, in shipbuilding , pressure vessels etc.

RE-DRY CONDITION : Re-Dry the electrode at 120°C for one hour, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max.	0.50-1.00	0.50 Max	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
400-500	500-600	22-28	0°C : 50-100 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC-/AC)	No. of Pcs./pkt.	No. of Pcs./Case
3.15/3.20 X 450	1/ 8"X18"	140-170	75	300
4.00 X 450	5/ 32"X18"	190-240	45	180
5.00 X 450	3/ 16"X18"	230-290	25	60

Customer packing on request.