



PRODUCT DATA SHEET

FULL IRON POWDER ELECTRODES

PH7024



SUMMARY

- > An iron powder electrode
- > Extremely easy slag removal
- > Virtually no spatter
- > Instant striking and re-striking
- > Produces high efficiency and the highest deposition rates

IDENTIFICATION

Coating - Black **Tip** - White **Imprint** - PH7024 4924A

CLASSIFICATION

- > AS/NZS 4855B E4924A
- > AWS A5.1 E7024

DESCRIPTION AND APPLICATION

The Weldwell PH7024 is a heavy coated rutile contact type electrode developed for high speed welding of mild steel in the down-hand and horizontal positions using AC or DC current. The high iron powder content in the flux coating gives high efficiency combined with excellent mechanical properties and weldability.

Suitable for welding Dozers, Buckets, Ship Building, Roof Trusses, Rolling Stock, Bridge Girders, Crusher Frames, Pressure Vessels, Heavy Machinery Frames, Tank Bottom Welding, Beams and Blades.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
3.2	380	130 - 160
4.0	455	180 - 210
5.0	455	260 - 320

*Recommended for DC +/- or AC (minimum 50 OCV).
Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

- > **Lloyd's Grading** - D BF 2Y
- > **BV Grade** - 2
- > **ABS Grade** - 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si
0.05	0.59	0.36

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	447 MPa
Tensile Strength	507 MPa
Elongation	31%
CVN Impact Values	71 J @ 0°C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER KG	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
3.2	5.0	3	96	PH702432
4.0	5.0	3	54	PH702440
5.0	5.0	3	32	PH702450

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