

# ES 7024

Type Rutile

SMAW

E7024

**ESWECO**  
*The Art of Welding*

## Description

High-recovery rutile electrode for the high productivity welding of fillets in the horizontal-vertical position. Particularly suitable for welding thick plates and for long run-out lengths. Good bead appearance. Easy slag removal.

## Recovery

130%

## Current

AC, DC+ - OCV 50 V



## Classifications

SFA/AWS A5.1	E7024
EN 499	E 42 0 RR 53
ISO 2560	E 51 3 RR 140 34

## Typical all weld metal composition, %

C	Si	Mn
< 0.12	0.4	0.7

## Typical mech. Properties all weld metal

Yield stress, MPa	>420
Tensile strength, MPa	510-610
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
0	>47
-20	>28

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	450	130-150	23
4.0	450	150-220	26
5.0	450	220-270	26