

SMAW

For High Tensile Steel

STABLEARC 24

CLASSIFICATION : AWS A5.1 E7024

JIS Z3212 D5000

WELDING POSITIONS :



- High Iron Powder, Rutile Type Electrodes
- High Deposition Rates And Efficiencies
- Self Releasing Slag
- Suitable For Fast Downhand Fillet And Butt Welding

Approval	
Lloyds Register Of Shipping	Grade 2
American Bureau Of Shipping	Grade 2

DESCRIPTION AND APPLICATIONS

STABLEARC 24 is a high iron powder, rutile type electrode designed for the fast downhand welding of mild steel using AC or DC power sources.

Features including high deposition rates/efficiencies and flat to slightly concave fillet welds with excellent "edge wash" and slag detachability.

With its smooth running, positive re-strike and high current carrying capacity, these electrode is ideal for downhand positions aimed at higher productivity. STABLEARC 24 is suited for long, heavy fillet and butt welding applications using a touch welding or short arc technique. Such applications include the production welding of tanks, structural members/frames and truck and tractor bodies etc.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S
0.07	0.7	0.4	0.016	0.014

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
440 N/mm ²	490 N/mm ²	27%	60J @ 0°C

- in "as welded" condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	PACKAGING (kg)	
			PKT	CTN
3.2	450	120 - 170	5	20
4.0	450	200 - 240	5	20
5.0	450	270 - 320	5	20

- Recommended for DC+ or AC (minimum 50 OCV) operation

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