



CEWELD E 7024 (200)

TYPE High efficiency, rutile electrode with approximately 200% metal recovery.(Typ E7024, E42 0)

APPLICATIONS CEWELD® E 7024 (200) is a high-performance electrode with a thick rutile coating and a deposition rate of 200%. For joining and surfacing in machine, car body and wagon construction as well as in the manufacture of tanks and containers and in shipbuilding. This electrode can also be used for all types of steel structures

PROPERTIES CEWELD® E 7024 (200) has a high current carrying capacity and good striking properties. This electrode is very economical thanks to low spattering losses and easy slag removal.

CLASSIFICATION

AWS	A 5.1: E 7024
EN ISO	2560-A: E 42 0 RR 73
F-nr	1
FM	1

SUITABLE FOR **Rp< 420 MPa (60ksi) ISO 15608: 1.1** ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)

1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932

S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL

A, B, D

ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.08	0.3	0.75	0.025	0.025

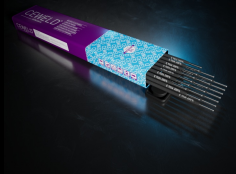
MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				0°C		
As Welded	450	550	23	65		HRc

REDRYING 140°C / 2 hr

CURRENT TYPE: AC, DC+/-

GAS ACC. EN ISO 14175



CEWELD E 7024 (200)

E 7024 (200) 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663400857

E 7024 (200) 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050774