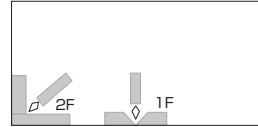


Stick electrode

Features:

- Suitable for flat and horizontal fillet welding
- Good welding usability in manual and gravity welding

Welding Positions:



Classification: AWS A5.1 E7024

Redrying Conditions: 70~100°Cx0.5~1h

Identification color: -

Polarity: AC, DCEP, DCEN

Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	400	5	20	57	175W, 115H, 430L
4.0	450	5	20	101	175W, 115H, 480L
5.0	450	5	20	147	175W, 115H, 480L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty ^a
C	0.09	0.15
Si	0.35	0.90
Mn	0.63	1.25
P	0.017	0.035
S	0.008	0.035
Ni	0.01	0.30
Cr	0.03	0.20
Mo	0.01	0.30
V	0.01	0.08
Others^b	0.69	1.50

Note: ^a Single values are maximum.

^b Combined Limit for Mn+Ni+Cr+Mo+V

Welding parameters (A)

φ mm	1F, 2F
3.2	120~150
4.0	170~210
5.0	220~260

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	470	400min.
TS (MPa)	540	490min.
EI on 4d (%)	27	17min.
IV 0°C (J)	55	-

Approvals

LR	2Ym
DNV	2YH15
NK	KMW52