

NST E 7024

AWS: A5.1 E7024

EN ISO 2560-A: E 42 0 RR 74



Rutile high efficiency electrode for welding unalloyed steel.

General description:

NST E 7024 is a high efficiency, rutile electrode for high productivity welding in heavy fabrications and ordinary structural steels, exhibiting excellent welding properties.

Very good choice for vertical fillet welding.

Tensile strength up to 510 N/mm² and approximately 200% efficiency.

Welding positions:



Welding current:

DC-/AC

Redrying:

250 °C/1 hour

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S					
0,08	0,30	0,75	<0,035	<0,035					

Diffusible hydrogen content (ml/100g):

Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) 0 °C	
≥420	500-640	≥22	≥47	

Guidance - Ampere (DC-/AC):

Electrode diameter	3,2 mm	4,0 mm	5,0 mm
Ampere / Volt	130-180	180-220	240-290

Packaging information:

3,2 x 450 2,5kg pack, carton 15,0kg
4,0 x 450 2,5kg pack, carton 15,0kg
5,0 x 450 2,5kg pack, carton 15,0kg

Approvals:

DNV, CE

Reference / date:

NST E 7024,
English, 28.01.2016.

Perfect Welding

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