



**WELDCOTE**



**E7024**



**Carbon Steel Electrode**

**Description/Application:** Weldcote 7024 electrode a high speed rutile and iron powder coated for single pass welding on horizontal or flat fillet welds. The thick flux coating gives this electrode greater deposition efficiency and a slightly convex to flat weld bead with a rippled appearance. The arc is stable and quiet with low spatter and shallow penetration into the base metal. The slag is heavy and peels off easily. Applications are heavy construction and earth moving equipment, truck bodies, ships, barges, railcars, bridges, storage tanks, etc. Welding position shall be flat or horizontal.

**Specifications/Classification:** AWS A5.1 & ASME SFA-5.1 / E7024

**Typical Chemical Composition**

Carbon	0.090%
Silicon	0.350%
Phosphorus	0.019%
Manganese	0.780%
Nickel	0.070%
Sulfur	0.014%
Chromium	0.060%
Molybdenum	0.010%
Vanadium	0.020%
Iron	Balance

**Typical Mechanical Properties of Weld Metal:**

Tensile Strength (psi)	82,000
Yield Strength (psi)	70,000
Elongation % in 2"	26
Charpy V-notch at 32°F	40 ft. lbs.
Reduction in area (%)	30-40

*Procedures may vary with change in position, base metals, equipment and other changes.*

**Recommended Welding Parameters**

DCEN, AC or DCEP Use a dragging short arc with 10-15% from 90°

	3/32"	1/8"	5/32"
Amps	100-130	130-170	180-220
Volts	24-26	26-27	26-28

Available sizes: 3/32", 1/8" & 5/32" in 50 lb. containers

842 Oak Grove Rd.  
Kings Mountain,  
NC 28086  
877-866-4115

1930 S. Carlos Ave.  
Ontario, CA 91761  
866-923-2167

40 Messina Dr.  
Braintree, MA 02184  
877-935-3268

5994 Griggs Rd.  
Houston, TX 77023  
866-516-0095

258 S. Kitley Ave.  
Indianapolis, IN  
46219