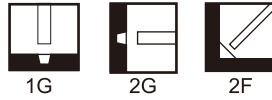


EASYARC™ 7024 is an iron-powder titania type high recovery electrode for down hand welding of mild steels. The easily controlled arc of EASYARC™ 7024 makes it easy to use on either AC & DC polarity. EASYARC™ 7024 provides stable arc, easy slag removal and excellent bead appearance.

APPLICATION

EASYARC™ 7024 can be used for high recovery welding of mild steel. It's also suitable for horizontal and flat fillet welding of thick plates for application such as shipbuilding, construction and bridge.

WELDING POSITIONS



CONFORMANCE

AWS A5.1/ ASME SFA-5.1: E7024

LINCOLN ADVANTAGE

- High recovery
- Easy slag removal
- AC & DC
- Good bead appearance
- Manufactured under a quality system certified to ISO 9001:2001 requirements

GUIDELINES FOR USE

- Exposed electrodes should be baked at 250°C for 60 minutes.
- All water, rust and oil should be completely removed from base material to prevent cracks and blowholes.

PACKAGING TYPE

The electrodes are placed inside packets and then sealed in plastic. 4 packets of electrodes are then placed inside a carton. For large shipments, the cartons are securely stacked on wooden pallets and covered with shrink-wrap plastic.

AVAILABLE SIZE/PACKAGING

Diameter × Length (mm × mm)	Weight (kg)		Packet per Carton	Product No.
	Packet	Carton		
3.2 x 400	5	20	4	CC010601
4.0 x 450	5	20	4	CC010602
5.0 x 450	5	20	4	CC010603
5.8 x 450	5	20	4	CC010604

MECHANICAL PROPERTIES, ALL WELD METAL

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)	Impact ISO -V, (J) 0°C
AWS A5.1 E7024 Requirement (Min.)	400	490	17	27
Typical Values	438	535	27	77

IRON POWDER MILD STEEL STICK ELECTRODE

EASYARC™ 7024

CHEMICAL COMPOSITION, ALL WELD METAL

	C	Mn	Si	S	P	Ni	Cr	Mo	V
AWS A5.1 E7024 Requirement (%) (Max.)	0.12	1.25	0.90	0.035	0.040	0.30	0.20	0.30	0.08
Typical Values (%)	0.045	0.83	0.42	0.018	0.026	0.028	0.027	0.003	0.004

RECOMMENDED WELDING CURRENT(AC, DC)

Diameter × Length (mm × mm)	3.2 x 400	4.0 x 450	5.0 x 450	5.8 x 450
Current (A)	100-150	170-220	210-260	250-310

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.



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