

KOBE-7024 **FAMILIARC™**

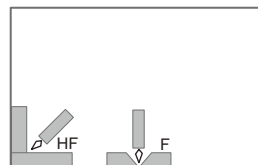
Iron-powder titania type covered electrode

Classification: ASME / AWS A5.1 E7024
 EN ISO 2560-A-E 42 0 RR
 JIS Z3211 E4924

Features: •Suitable for flat and horizontal fillet welding
 •Good welding usability in manual and gravity welding

Redrying Conditions: 70~100°Cx0.5~1h

Welding Positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.09	0.35	0.63	0.017	0.008
Guaranty	≤0.15	≤0.90	≤1.25	≤0.030	≤0.030

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	470	540	27	0°C: 55
Guaranty	≥400	≥490	≥17	-

Recommended welding parameters

	3.2mm	4.0mm	5.0mm
Dia.	3.2mm	4.0mm	5.0mm
F, HF	120-150A	170~210A	220~260A

Polarity

Example	DCEP
Guaranty	DC-EP, AC, DC-EN

Packages

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton(kg)	Weight per piece(g)
3.2	400	5	20	57
4.0	450	5	20	101
5.0	450	5	20	147