

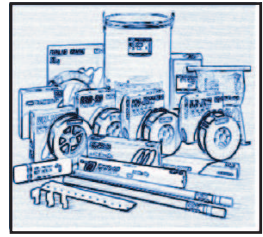
**Shielded Metal Arc Welding**

**ANU BOND- 724 (E 7024)**

AWS: A 5.1, E 7024, IS: 814 ERR 5242XK

**Application :**

Welding of heavy structures & machinery parts. Crane, Bridge, Girders. Ship Building. Earthmoving equipment's, Pressure Vessels. Welding of thick plates in Penstocks.



**Characteristics on Usage :**

A heavy coated iron powder type electrode with a deposition efficiency of approximately 140%. It is touch welding electrode with high deposition rate of flat and horizontal position. The electrode is easy to manipulate and give smooth arc with radiographic quality of welds. It can be used at high current and gives high welding productivity.

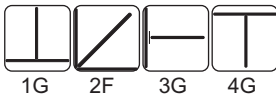
**Chemical composition of All-Weld metal (%) as per AWS**

C	Mn	Si	S	P
0.15 Max	1.25 Max	0.90 Max	0.035 Max	0.035 Max

**Mechanical properties of all-weld metal as per AWS**

UTS	Y. S.	Elongation	Impact
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L=4d ) %	(CVN) AT 0 <sup>0</sup> C (J)
490Min	400 Min	22 % Min	47 Joules Min

**Welding Positionsren**



**Packaging & Welding Curt**

SIZE (mm)	Kg Per Packet	Kg Per Carton	Current (Amps)	In Amps
2.50 x 350	2.50 Kg	12.5 Kg	AC / DC (+-)	80-120
3.15 x 450	3 Kg	15 Kg		130-170
4.00 x 450	3 Kg	15 Kg		180-240
5.00 x 450	3 Kg	15 Kg		250-290

