



IRON POWDER 7024

Gives maximum deposition in a short space of time

HIGH DEPOSITION EFFICIENCY | E7024 MILD STEEL ELECTRODES.

ISOARC Iron Powder 7024 is a high-speed, heavy-coated electrode designed specifically for high-deposition welding in flat and horizontal fillet positions. Incorporating a high percentage of iron powder in the coating, it delivers exceptionally high recovery rates, a smooth and stable arc, and minimum spatter. The slag is completely self-detaching, leaving an exceptionally smooth bead profile with fine ripples

Features & Benefits	Typical Applications
▪ Exceptionally high deposition efficiency (up to 140% recovery) ▪ Smooth, stable arc with negligible spatter level ▪ Self releasing slag with minimal post weld cleanup ▪ Excellent bead appearance ▪ Suitable for AC and DCEP ▪ High linear travel speeds for maximum productivity	▪ Structural steel fabrication ▪ General engineering ▪ High Speed downhand horizontal fillet and lap welds ▪ Shipbuilding, earthmoving equipment, and rail car production ▪ Heavy Fabrication deep groove butt welds

Technical Information

Classification	ASME :AWS A5.1 E7024, EN ISO 2560-A: E 42 0 RR 73
Polarity	AC / DCEP
Welding Positions	▪ Flat ▪ Horizontal
Base Materials	Carbon steels and low alloy steels
Storage	Store in a dry area off the ground

Mechanical Properties	Typical
Tensile Strength	510 - 590 MPa
Yield Strength	> 420 MPa
Elongation	≥ 22%

	Current Range
3.2mm	130 - 180A
4.0mm	180 - 240A
5.0mm	240 - 320A



Manufactured by Thuthuka Welding Products (Pty) Ltd

Manufactured under an ISO 9001 quality management system using internationally proven formulations to deliver consistent welding performance and dependable quality.