

**ROYAL - 724 (E 7024)**AWS : A 5.1, E 7024  
IS : 814 ERR 5242XK**Applications**

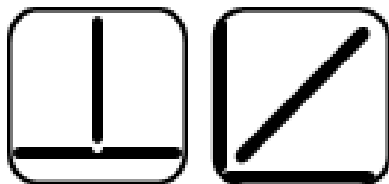
Welding of heavy structures & machinery parts. Crane, Bridge, Girders. Ship Building. Earthmoving equipment's, Pressure Vessels.

**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 for flat and horizontal position. The electrode is easy to manipulate and gives smooth arc with radiographic quality of welds. It can be used at high current and gives high welding productivity.

**Notes On Usage**

- ✍ 1) Optimum speed ratio is 1-1.5%.
- ✍ 2) Usability degrades when moistened. In case of absorbing moisture, it must be dried. [70-100°C for 30-60 min.]

**Welding Positions**

1G

2F

**Chemical Composition Of Weld Metal**

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

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT 0° C
490 Min	400 Min	22 % Min	47 Joules Min

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 X 350	120	480	AC/DC ( ± )	80 – 120
3.15 X 450	75	300		130 – 170
4.00 X 450	45	180		180 – 240
5.00 X 450	25	100		250 – 290