



## FERROVITE

**CODIFICATION :** AWS : SFA 5.1 E7024

### CHARACTERISTICS AND APPLICATIONS :

A Super heavy coated, iron powder type electrode ideal for welding mild steel structures, plant machinery, etc. High metal recovery of 150% reduces welding time and increases the output. Weld metal is sound and is of radiographic quality. Some typical applications include mild steel structures, heavy columns, shipbuilding, locomotives, girders, boilers, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.07	0.56	0.24	0.025	0.025

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at 0°C (Joules)
520	448	27.0	56

### CURRENT AND PACKING DATA: AC / DC(±)

Size (mm)	:	6.3x450	5x450	4x450	3.15x350
Dia x Length					
Current Range (Amps)	:	320-380	220-280	190-230	140-170
Qty.(Pcs./Carton)	:	20	30	45	50

### PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 150-200°C for one hour.
2. The electrode is meant for operation in flat and horizontal positions only.