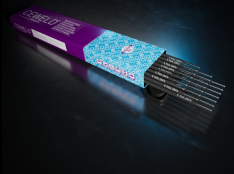




# CEWELD E 7024 (200)

| TYPE  | Dick Rutilumhüllte Hochleistungselektrode mit 200% Ausbringung. ( Typ E7024, E 42 0 )  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
|---|--|----------------|-------------------------|----------------------|----------------------|-------------------------|--------------------|-------------------------|----------|-----------|-------|-----|----|----|-----|
| ANWENDUNGEN                                 | CEWELD® E 7024 (200) ist eine Hochleistungselektrode mit dicker Rutilumhüllung und 200 % Ausbringung. Für Verbindungs- und Auftragschweißungen im Maschinen-, Karosserie-, Waggon-, Behälter- und Schiffbau. Darüber hinaus kann diese Elektrode für alle Arten von Stahlkonstruktionen verwendet werden.  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| EIGENSCHAFTEN                               | CEWELD® E 7024 (200) besitzt eine hohe Strombelastbarkeit und gute Kerbschlageigenschaften. Durch geringe Spritzerverluste und einfache Schlackenentfernung ist diese Elektrode sehr wirtschaftlich.   |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| KLASSIFIKATION                              | <table border="0"> <tr> <td>AWS</td> <td>A 5.1: E 7024</td> </tr> <tr> <td>EN ISO</td> <td>2560-A: E 42 0 RR 73</td> </tr> <tr> <td>F-nr</td> <td>1</td> </tr> <tr> <td>FM</td> <td>1</td> </tr> </table>  | AWS            | A 5.1: E 7024           | EN ISO               | 2560-A: E 42 0 RR 73 | F-nr                    | 1                  | FM                      | 1        |           |       |     |    |    |     |
| AWS   | A 5.1: E 7024  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| EN ISO                                      | 2560-A: E 42 0 RR 73   |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| F-nr  | 1  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| FM  | 1  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| GEEIGNET FÜR                                | <p><b>Rp &lt; 420 MPa (60ksi) ISO 15608: 1.1</b> ReH &lt; 275 MPa, 1.2 275 &lt; ReH &lt; 360 MPa , (1.3 ReH &gt; 360 MPa &lt; 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932</p> <p>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D</p> <p>ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)</p> |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| ZULASSUNGEN                                 | CE   |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| SCHWEISSPOSITIONEN                          |  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.3</td> <td>0.75</td> <td>0.025</td> <td>0.025</td> </tr> </tbody> </table>  | C              | Si                      | Mn                   | P                    | S                       | 0.08               | 0.3                     | 0.75     | 0.025     | 0.025 |     |    |    |     |
| C   | Si   | Mn             | P                       | S                    |                      |                         |                    |                         |          |           |       |     |    |    |     |
| 0.08  | 0.3  | 0.75           | 0.025                   | 0.025                |                      |                         |                    |                         |          |           |       |     |    |    |     |
| MECHANISCHE GÜTEWERTE                       | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>0°C</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>450</td> <td>550</td> <td>23</td> <td>65</td> <td>HRc</td> </tr> </tbody> </table>   | Heat Treatment | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%)   | Impact Energy (J) ISO-V |                    | 0°C                     | Hardness | As Welded | 450   | 550 | 23 | 65 | HRc |
| Heat Treatment                              | R <sub>p0,2</sub> (MPa)  |                |                         |                      |                      | R <sub>m</sub> (MPa)    | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |          |           |       |     |    |    |     |
|   |  | 0°C            | Hardness                |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| As Welded                                   | 450  | 550            | 23                      | 65                   | HRc                  |                         |                    |                         |          |           |       |     |    |    |     |
| RÜCKTROCKNUNG                               | 140°C / 2 hr   |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| CURRENT TYPE:                               | AC, DC+/-  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |
| GAS ACC. EN ISO 14175                       |  |                |                         |                      |                      |                         |                    |                         |          |           |       |     |    |    |     |



# CEWELD E 7024 (200)

E 7024 (200) 4,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3,2     | 8720663400857 |

E 7024 (200) 5,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Vacuum    | 2,8     | 8720682050774 |