



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# 7024 Carbon Steel Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



## ALLOY DESCRIPTION AND APPLICATION;

**E7024 is an iron powder, rutile coated electrode designed for high speed, single pass horizontal and flat fillet welding of mild steel. This electrode provides greater deposition efficiency and better physical properties than E7014 electrodes. E7024 offers a quiet stable arc and produces weld deposits with low spatter, free of undercuts and a "self-removing" slag. Bead appearance is superb. This electrode may be used with AC or DC (straight or reverse polarity). Ship/Barge structures, bridges, structural steels, machine bases, truck fabrication, storage tanks and earth-moving equipment.**

### TYPICAL WELDING PROCEDURES; AC or DCEN

Diameter	Amps (Flat)	Volts	Diameter	Amps (Flat)	Volts
3/32"	70-170	21-26	3/16"	180-390	26-30
1/8"	120-160	25-27	7/32"	250-320	25-30
5/32"	150-230	26-30	1/4"	280-380	26-31

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

### TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld Metal		AWS Spec.	Weld Metal
Carbon	0.15 max	0.09	Chromium	0.20 max	0.04
Manganese	1.25max	0.78	Molybdenum	0.30 max	0.01
Silicon	0.90 max	0.35	Vanadium	0.08 max	0.02
Phosphorus	0.035 max	0.019	Elongation in 2" (%)	22% min	26%
Sulphur	0.035 max	0.014	Yield Strength (ksi)	58 min	72
Nickel	0.30 max	0.07	Tensile Strength (ksi)	70 min	81
Mn + Ni + Cr + Mo + V	1.50 max		Charpy V-notch	N/S	48

**AVAILABLE SIZES: TE 7024 = 3/32", 1/8", 5/32", 3/16", 7/32", 1/4"**

**SPECIFICATIONS; ANSI/AWS A5.1 E7024  
ASME SFA 5.1 E7024 F-1,A1**

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