



IN COLLABORATION WITH:
Kjellberg
 FINSTERWALDE
 ESTD. 1922
 EN ISO 9001:2000

Kjellberg Finsterwalde Elektroden und Maschinen GmbH, Germany

Product Data Sheet

SUPER OPTIMAL 7024

Classification: AWS A 5.1 : E 7024 EN 499 : E 42 0 RR 53 ISO 2560-A: E 42 0 RR 53

Description & Applications: High efficiency, Iron powder electrode designed for outstanding deposition rates. Deposition efficiency is approximately 140—150 % .Excellent arc stability, soft fusion, fine ripples, self releasing slag, very low spatter.

Applied for heavy steel structures, storage tanks, bridge girders, fabrication of earth moving equipments, pressure vessels etc.

Frequently used for butt-welding plates with a heavy thickness and for fillet welds

Base Materials:

Construction steels for general use , Tube steels, Ship steels

EN- Designation:	S185 – S355	L210 – L360
	P235 – P355	
Ship steels:	Quality A and B	
ASTM:	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

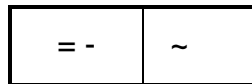
**Typical weld metal
Chemical Composition (%)**

C	Si	Mn	S	P
0.10	0.40	0.90	0.020	0.025

**All weld metal mechanical
properties
(typical)**

Yield strength N/mm ²	Tensile strength N/mm ²	Elongation A ₅ %	Charpy impact value ISO-V J +20°C
>400	510-600	24	>64

**Welding
recommendations:**



Welding positions:



Current conditions:

Diameter (mm)	Length (mm)	Current (A)
3.15	350 & 450	120-150
4.00	450	150-190
5.00	450	180-230

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