

SMAW Electrodes

GL24

AWS A5.1M E4924 / A5.1 E7024
JIS Z 3211 E4903
ISO 2560-A-E 42 0 RA

Product Features:

- Lime Titanium oxide type covered electrode for high tensile strength steel.
- High arc stability and easy to re-arc.
- High welding efficiency and good manipulation ratio.
- Acid type slag, easy to remove.

Applications:

- Suitable for welding of thickness $\leq 25\text{mm}$, 490 N/mm² high tensile strength steel structures on shipbuilding, vehicles, buildings, bridges, tanks, pressure vessels and general mechanical steel structures.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.10	0.26	0.67	0.021	0.009	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (0°C) J
440	511	32	74

Size (mm) & recommended welding parameters (A) AC or DC±

Diameter / Length	3.2/350	4.0/400/450	5.0/450
Flat position	100~140	160~200	200~250

Note:

- 100~150°C x 1 hr baking prior to use.

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