| **Classification** | **AWS A 5.1 :** E 7024 | **EN 499 :** E 42 0 RR 73 | **ISO 2560-A:** E 42 0 RR 73 |

Description and Application

Rutile type heavy coated iron powder electrode with an efficiency of 165% approx. It is designed for butt and fillet welds, used for filling large weld sections and making long fillet welds. Excellent arc stability, soft fusion, fine ripples, self releasing slag, very low spatter. Easy arc striking and re-striking. 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
0.08	0.40	0.80	0.020	0.025

All weld metal Mechanical Properties (Typical)

Yield strength $R_p(N/mm^2)$	Tensile strength $R_m(N/mm^2)$	Elongation A5 (%)	Charpy impact value ISO-V J +20°C
$\geq$400	510-600	$\geq$24	$\geq$60

Amperes (A)

2.40mm	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm	4.80mm	5.00mm
70-110	80-120	120- 150	120- 150	120- 150	150- 190	180-230	180-230

Welding instruction

Keep dry and avoid condensation.

Welding Positions

PA   PB   =±   ~
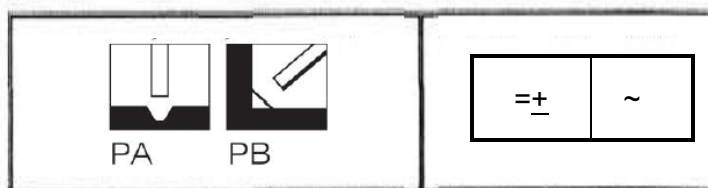
Stellaris Specialities India Ltd.
(Division: StarBlaze India)
GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850
Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020
Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001
Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064
Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707
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