

# CR-24

For highly efficient fillet welding

AWS A5.1 E7024  
KS D 7004 E4324  
JIS Z3211 E4324

## Applications

Horizontal and flat fillet welding of ship buildings, structural steels of buildings, general structures and surface dressing of multi-layer welds.

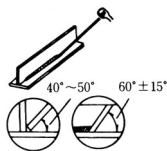
## Characteristics

CR-24 is an iron powder high titania type electrode which is designed for the purpose of obtaining high efficiency in single pass horizontal and flat welding.

It has excellent arc re-striking property and slag is almost self-lifting. The bead appearance is lustrous. In case of manual welding, the applicable speed ratio is wide from 0.8 to 1.6. As its deposition efficiency and deposition rate are high, extremely high working efficiency can be obtained.

## Notes on usage

- (1) In the case of horizontal fillet welding, manipulate the electrode keeping its tip in contact with mother plate as shown in the sketch.
- (2) In the case of horizontal fillet welding, keep the optimum speed ratio among 1.0~1.5
- (3) Dry the electrodes at 70~100°C for 30~60 minutes before use because excessive moisture absorption causes undercuts and irregular beads.



## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.08	0.70	0.35	0.018	0.012

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)
			0°C
480(49)	560(57)	28	70(6.9)

## Size & recommended current range (AC or DC ±)

Dia. (mm)		3.2	4.0	4.5	5.0	5.5	6.0	6.4
L (mm)		400	450 550	450 550	450 550	450 550	450 700	450 700
Amp.	F&H-F	100-150	140-190	170-220	200-250	230-280	250-310	280-330

• Approval : ABS

• Tip Color : Yellow