DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM7024 Premium Electrode

Classification: **E7024**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM7024 is a IRON POWDER, TITANIA COATED TYPE WELDING ELECTRODE

CHARACTERISTICS, FEATURES & APPLICATIONS

DURAMAX E7024 electrode coverings contain large amounts of iron powder in combination with ingredients similar to those used in E6013 electrodes. The coverings on DM7024 are very think and usually amount to about 50% of the weight of the electrode, resulting in higher deposition efficiency. The DM7024 electrodes are well suited for making fillet welds in the flat or horizontal position. Weld face is slightly convex to flat, with a very smooth surface and a very fine ripple. These electrodes are characterized by a smooth, quiet arc, very low spatter, and low arc penetration. They can be used with high travel speeds. Electrodes of this classification can be operated on AC, DCEP or DCEN. DM7024 is an excellent choice for earthmoving equipment, railroad cars, mining machinery, structurals, plate fabrication, shipbuilding, and mobile trailers.

Typical All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.15 max	1.25 max	0.90max	0.035 max	0.035 max	0.30 max	0.20 max	0.30 max	0.08 max
Mn + Ni + Cr + Mo + V = 1.50 max								

All Weld Mechanical Properties

UTS (N/mm²)	YS (N/mm²)	EL % (1=4d)	CVN Impacts (J) @ -20°C
490 min	400 min	17% min	≥ 27 J

Sizes available and recommended currents (DC +, DC- or AC)

SIZE	3/32	1/8	5/32	3/16
AMPS	100 - 145	140 - 190	180 - 250	230 - 305

POLARITY: DCEP, DCEN or AC
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930