



PRODUCT DATA SHEET

IRON POWER ELECTRODES

WCD 6106

Austarc 24



SUMMARY

- > High Iron Powder, Rutile Type Electrode
- > High Deposition Rates and Efficiencies
- > Suitable for Fast Downhand Fillet and Butt Welding

IDENTIFICATION

Coating - Brown **Tip** - Yellow **Imprint** - WIA 4924A

CLASSIFICATION

- > AS/NZS 4855-B - E49 24 A
- > AWS A5.1: E7024

DESCRIPTION AND APPLICATION

A high iron powder, rutile type electrode designed for the fast down hand welding of mild steel using AC or DC power sources. Features include high deposition rates/efficiencies and flat to slightly concave fillet welds with excellent "edge wash" and slag detachability. With its smooth running, positive re strike and high current carrying capacity, Austarc 24 is the ideal fillet welding electrode for down hand positions aimed at higher productivity.

Austarc 24 is suited to long, heavy fillet and butt welding applications using a touch welding or 'short arc' technique. Such applications include the production welding of tanks, structural members/frames and truck and tractor bodies etc.

OPERATIONAL DATA

| ELECTRODE SIZE (MM) | ELECTRODE LENGTH (MM) | WELDING CURRENT RANGE *(A) | ARC VOLTAGE RANGE **(V) |
|---------------------|-----------------------|----------------------------|-------------------------|
| 4.0 | 450 | 180 - 210 | 25 |

*Recommended for DC +/- or AC (minimum 55 OCV) operation.
 **Voltage is determined by arc current and electrode arc length.
 Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

LRS 2Ym ABS 2 DNV 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| C | Mn | Si | P | S | Fe |
|------|------|------|-------|-------|-----|
| 0.05 | 0.99 | 0.42 | 0.017 | 0.011 | Bal |

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| | |
|-------------------|-----------|
| Yield Stress | 416 MPa |
| Tensile Strength | 510 MPa |
| Elongation | 32% |
| CVN Impact Values | 60J @ 0°C |

PACKAGING DATA

| ELECTRODE SIZE (MM) | PACKAGING (KG) | | APPROX. NO. OF RODS PER KG | PART NO. |
|---------------------|----------------|--------|----------------------------|----------|
| | PACKET | CARTON | | |
| 4.0 | 5.0 | 15 | 12 | 2440 |

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