

AWS E7024 (E4824*)

**DESCRIPTION:**

Hobart Rocket 7024 is a newly engineered E7024 electrode designed to provide the user with outstanding "best of class" features in several important areas. Rocket 7024 is engineered with a slag system to provide the easiest slag removal in its class and in most cases is self peeling. In addition the slag releases from the entire joint with no slag left in the toes of the joint. Spatter levels are extremely low, better than any other E7024. Rocket 7024 has a super smooth soft arc and is less harsh than other E7024 products. Rocket 7024 is more forgiving than other E7024 products when the material being welded is moderately rusty or isn't as clean as it should be. Rocket 7024 can be used with a drag welding technique and operates equally well on either AC or DC (electrode negative) power. It is exceptionally fast when used down hand in properly designed weld joints or in horizontal fillet welds and can be used in single or multi-pass applications.

APPLICATIONS:

Plate fabrication, tank fabrication, barge construction, construction and earth moving equipment.

FEATURES:

- Self-removing slag system
- Low spatter levels
- Smooth, soft arc
- Less affected by rusty, mill scaled materials
- Finely rippled, flat weld face
- High deposition, fast fill

BENEFITS:

- Quick clean-up, increased productivity
- Post weld clean-up time reduced
- High welder satisfaction
- Less preparation, more welding
- Finished, professional appearance
- Easy to use with drag technique

TYPICAL WELD METAL PROPERTIES*(Chem Pad):

Weld Metal Analysis		AWS Spec (max)
Carbon (C)	0.074	not required
Manganese (Mn)	0.680	1.25
Silicon (Si)	0.406	0.90
Phosphorus (P)	0.012	not required
Sulphur (S)	0.014	not required

TYPICAL MECHANICAL PROPERTIES*(AW):

		AWS Spec (min)
Tensile Strength	76,000 psi (524 MPa)	70,000 psi
Yield Strength	68,000 psi (469 MPa)	58,000 psi
Elongation % in 2"	19%	17%
Reduction of Area	30% to 40%	not required

TYPICAL CHARPY V-NOTCH IMPACT VALUES*(AW):

		AWS Spec
Avg. at 0°F (-18°C)	40 ft•lbs (54 Joules)	not required

TYPE OF CURRENT: DCEN, AC or DCEP

CONFORMANCES AND APPROVALS:

- AWS A5.1, E7024, ASME SFA 5.1, F-1, A-1

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with AWS A5.29 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

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RECOMMENDED WELDING PROCEDURE:

- GENERAL:** Electrode negative, work positive (DCEN) AC or electrode positive, work negative (DCEP)
ARC LENGTH: Short arc or drag technique
FLAT: Use faster speed of travel; angle electrode 30° from 90°
VERTICAL-UP: Not recommended
VERTICAL-DOWN: Not recommended
OVERHEAD: Not recommended
STORAGE: 60°F to 100°F, (20° to 40°C); and below 50% relative humidity or holding oven @ 100° to 120°F (38° to 49°C)
RECONDITIONING: 250°F to 300°F, (121° to 149°C) for one hour @ temperature

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Minimum Amps	Optimum Amps	Maximum Amps
Inches	mm				
1/8	3.2	DCEN, AC, or DCEP	130	160	170
5/32	4.0	DCEN, AC or DCEP	180	220	245
3/16	4.8	DCEN, AC or DCEP	200	260	300
7/32	5.6	DCEN, AC or DCEP	250	300	340
1/4	6.4	DCEN, AC or DCEP	300	350	380

TYPICAL DEPOSITION DATA (at optimum):

Diameter		Type of Power	Amps	Deposition Rate lbs/hr	Deposition Efficiency*%
Inches	mm				
1/8	3.2	DCEN	160	3.86	66.0
5/32	4.0	DCEN	220	5.70	66.2
3/16	4.8	DCEN	260	7.64	68.2
7/32	5.6	DCEN	300	9.48	69.1
1/4	6.4	DCEN	350	11.04	68.6

*Allowance made for 2" sub loss included

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		50-Lb. Carton
Inches	mm	Inches	mm	
1/8	3.2	14"	355	S112944-031
5/32	4.0	14"	355	S112951-031
3/16	4.8	18"	457	S112959-031
7/32	5.6	18"	457	S112970-031
1/4	6.4	18"	457	S112981-031

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service.

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