

JETWELD® 1

Mild Steel, High Deposition · AWS E7024-1

KEY FEATURES

- High deposition rates
- Smooth bead appearance
- Shallow penetration

CONFORMANCES

AWS A5.1:	E7024-1
ABS:	E7024-1
CWB/CSA:	E4924-1

TYPICAL APPLICATIONS

- Large welds
- Slightly downhill (15° max) positions
- Multiple pass welding

WELDING POSITIONS

Flat & Horizontal

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	10 CPL (40CT)
1/8 [3.2]	14 [350]	ED038330
5/32 [4.0]	14 [350]	ED038331
3/16 [4.8]	18 [450]	ED038332
7/32 [5.6]	18 [450]	ED038333
1/4 [6.4]	18 [450]	ED038334

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.1

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @ -18°C (0°F)
Requirements - AWS E7024-1	400 [58] min	490 [70] min	22 min	27 [20] min
Typical Results⁽³⁾ - As-Welded	455-490 [66-71]	530-565 [77-86]	22-31	27-60 [20-44]

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.1

	%C	%Mn	%Si	%P	%S
Requirements - AWS E7024-1	0.15 max	1.25 max	0.90 max	0.035 max	0.035 max
Typical Results⁽³⁾ - As-Welded	0.03-0.06	0.63-1.02	0.13-0.68	0.010-0.022	0.005-0.011
	%Ni	%Cr	%Mo	%V	%Mn + Ni + Cr + Mo + V
Requirements - AWS E7024-1	0.30 max	0.20 max	0.30 max	0.08 max	1.50 max
Typical Results⁽³⁾ - As-Welded	≤ 0.06	0.01-0.05	≤ 0.02	0.03 max.	0.75

TYPICAL OPERATING PROCEDURES

Polarity ⁽⁴⁾	Current (Amps)				
	1/8 in [3.2 mm]	5/32 in [4.0 mm]	3/16 in [4.8 mm]	7/32 in [5.6 mm]	1/4 in [6.4 mm]
AC	115-175	180-240	240-300	300-380	340-440
DC±	100-160	160-215	220-280	270-340	320-400

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer ⁽⁴⁾Preferred polarity is listed first.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment, or to provide engineering advice in relation to a specific situation. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

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