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COMERCIAL DESIGNATION: ESSEN MS 724 R

PATTERN: AWS E 7024

ALLOY ELEMENTS INCLUDED	C	Si	Mn

APPLICATION FIELD	The electrode ESSEN MS 724 R is a semi-automatic electrode of contact with approximatedly 180% of rentability and high welding speed, Specially indicated for bridges, ships, waggons, matallical structures, reservatories, boilers, etc. Fasten filled up of chamfers in V with big dimmensions and positioned angles in L. Excellent characteristics of ignition and re-ignition, high fusion speed, scoria easily removed and strings of beautiful aspect, insensible to magnetic blowing and without porosity.
TECHNICAL CHARACTERISTICS	Electrode with high rentability 180% for welding the contact systems in junctions on the top or in angles, to be mannually used for gravity, a lot of scoria.: Steel for construction: ST 33 – ST 52 – ST 37T – ST 52T Pipeline Steel: HI – HIII – ST 34KT – ST 47KT Fine-grain steel: Grupo de resist. 50-64 Kp/ mm² Steel for naval construction: A – D
MECHANICAL PROPRIETIES	Traction Resistance: 50-58 Kp/ mm² Elasticity Limit: 42-48 Kp/ mm² Extension: L= 5 d.%: 17 % Resilience Kpm/cm² D.V.M. 27%
OPERATIONAL CHARACTERISTICS	For C.A. ou C.C.-

Welding Position: P.

∅ In mm	3,25x350mm	4,00x450mm	5,00x450mm	6,00x450mm
Amperage Package	140-180 A 5 kg	200-250 A 5 kg	280-350 A 5 kg	350-420 A 5 kg

WELDING TECHNIQUES	Clean the area to prepare the junction. In big filling up use chamfers of 70 at least, avoiding to delete the area, remove the scoria before restarting the welding process.

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