

Hobart Rocket[®] 7024



AWS E7024 (E4824*)

WELDING POSITIONS:



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
- Higher welder satisfaction
- Less preparation, more welding
- Finished, professional appearance
- Easy to use with drag technique

APPLICATIONS:

- Plate fabrication
- Construction
- Tank fabrication
- Earthmoving equipment
- Barge construction

TYPE OF CURRENT: AC, Direct Current Electrode Positive (DCEP), or Direct Current Electrode Negative (DCEN)

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° 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° to 300°F, (121° to 149°C) for one hour @ temperature

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis (%)		AWS Spec (max)
Carbon (C)	0.05	0.15
Manganese (Mn)	0.74	1.25
Silicon (Si)	0.45	0.90
Phosphorus (P)	0.009	0.035
Sulphur (S)	0.019	0.035
Nickel (Ni)	0.07	0.30
Chromium (Cr)	0.06	0.20
Molybdenum (Mo)	0.01	0.30
Vanadium (V)	0.02	0.08
Mn + Ni + Cr + Mo + V	0.90	1.5

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests		AWS Spec (min)
Tensile Strength	82,000 psi (562 MPa)	70,000 psi (483 MPa)
Yield Strength	70,000 psi (483 MPa)	58,000 psi (400 MPa)
Elongation % in 2" (50 mm)	26%	17%
Reduction of Area	30% to 40%	Not required

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

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

*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 the 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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Diameter		Type of Current	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

Diameter		Type of Current	Amps	Volts	Deposition Rate		Deposition Efficiency %
Inches	(mm)				lbs/hr	(kg/hr)	
1/8	(3.2)	DCEN	160	26-27	3.86	(1.8)	66.0
5/32	(4.0)	DCEN	220	26-28	5.70	(2.6)	66.2
3/16	(4.8)	DCEN	260	26-28	7.64	(3.5)	68.2
7/32	(5.6)	DCEN	300		9.48	(4.3)	69.1
1/4	(6.4)	DCEN	350		11.04	(5.0)	68.6

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter		50-lb. (22.7kg) Carton
Inches	(mm)	
1/8	(3.2)	S112944-031
5/32	(4.0)	S112951-031
3/16	(4.8)	S112959-031
7/32	(5.6)	S112970-031
1/4	(6.4)	S112981-031

CONFORMANCES AND APPROVALS:

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

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

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