



# GEMINI 7024

## Typical Applications And Characteristics

GEMINI 7024 is a rutile coated iron power high recovery electrode depositing weld metal of good metallurgical properties quickly and economically. Designed for downhand and fillet welding. GEMINI 7024 has a recovery of approximately 160 %. The arc is smooth and consistent with very little spatter. Striking and re-striking qualities are excellent.

| Typical All-Weld Metal Properties |      |                             |         |                   |
|-----------------------------------|------|-----------------------------|---------|-------------------|
| Composition (%)                   |      | Mechanical                  |         |                   |
| C                                 | 0.05 | Yield strength              | >500    | N/mm <sup>2</sup> |
| Mn                                | 0.80 | Tensile strength            | 510-610 | N/mm <sup>2</sup> |
| Si                                | 0.40 | Elongation (5xd)            | >24     | %                 |
|                                   |      | Reduction of area           | 60      | %                 |
|                                   |      | Impact strength ISO-V@ 0 °C | 60      | Joule             |
|                                   |      | ISO-V@ -20 °C               | >60     | Joule             |

## Typical welding current

| AC or DC-           |         |         |         |         |         |
|---------------------|---------|---------|---------|---------|---------|
| Ø/L (mm)            | 2.0/300 | 2.6/300 | 3.2/350 | 4.0/400 | 5.0/400 |
| Current min/max (A) | 70/90   | 90/120  | 130/160 | 180/220 | 270/620 |

| International Standard |                   | Color             | End              | Blue |
|------------------------|-------------------|-------------------|------------------|------|
| AWS A5.1               | E 7024            | Coding            | Side             | Red  |
| ISO 2560               | E 513 RR 160 32   | Printing          | G-7024/E 7024    |      |
| DIN 1913               | E 51 32 RR 11 160 | Welding Positions | Flat, horizontal |      |