

JACKSUN ULTRA-24

EXTRA HEAVY COATED, IRON POWDER & RUTILE
TYPE WELDING ELECTRODE FOR HIGH
DEPOSITION EFFICIENCY 140% MIN.

BASIC ALLOY: FE, MN, SI

EN ISO 2560-A E 42 0 R 24

KEY FEATURES:

An extra heavy coated, iron powder, rutile type electrodes for achieving high deposition efficiency 140% Min. Electrode is touch welding type, gives smooth arc, least spatter losses, reduces welding time and gives increased productivity and output by using high current. Welds are of radiographic quality

APPLICATIONS

- Heavy sections machinery components.
- Heavy Structural works like cranes and bridges.
- Assembly of earthmoving equipment.
- Welding heavy columns, locomotive.
- Heavy machinery parts, in shipbuilding, pressure vessels etc..

RE-DRY CONDITION:

- Re-Dry the electrode at 120°C for one hour, for best results

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.10 max.	0.50-1.25	0.50 Max	0.030 Max	0.030 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
400 Min.	500	22 min	0C : 100-120 J

WELDING POSITION

1G/1F



2G/2F



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (DXL)	Size (inch) (DXL)	Current Condition (DC-/AC) Amps	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	70-110	5	20
3.15/ 3.20	1/ 8"	100-150	5	20
4.00	5/ 32"	160-200	5	20
5.00	3/ 16"	200-250	5	20