BASIC COATED - LOW HYDROGEN ELECTRODE

EURO 7015

CODING: AWS A 5.1 – E 7015

CHARACTERISTICS :

EURO 7015 is a basic coated low hydrogen electrode suitable for welding heavy structures, high tensile strength jobs where impact strength at sub-zero temperatures are required. The
basic coated formulation ensures a defect-free radiographic quality weld. The superb and well established flux formulation ensure excellent performance of the electrode in DC(+) in all welding positions except vertical down.

ADVANTAGES :

- Uniform and soft metal transfer
- Easy to control weld pool and slag.
- Suitable in DC (+).
- Suitable for difficult to weld steels
- Neat weld profile in fillet joints.
- High tensile strength and excellent toughness in sub-zero temperatures.
- Suitable for highly restrained joints

APPLICATIONS :

EURO 7015 is suitable for all sorts of joining, repairing and fabrication of structural works medium and high tensile steels of grade 550 N/sqmm., The applications include; welding of Structures, highly restrained joints, bridges, railway coaches & wagons, plants, ships, tugs, barges, trawlers, dredgers, storage tanks, boilers, pipelines, grills etc., The electrode can be used as a non-machinable electrode on castings.

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 450	5.00 X 450
CURRENT - Amps	DC(+)	70-100	90-140	140-200	190-250

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P	Mn+Ni+Cr+V
percent	0.09	1.00	0.60	0.020	0.020	<1.75%

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	% Redn. In area	CVN Impact value
460	540	26	75	47J at -20°C

Diffusible Hydrogen Content **:** 10 ml/100gms. Of weld
Radiographic evaluation **:** Meets the requirements of Grade-I.
Moisture content in the flux covering : <2.0%
Rebaking recommendations : The electrodes should be re-baked at 250°C for 2 hours or 350°C for one hour prior to use and maintained warm till the job is completed.