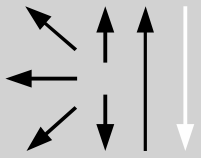


Classifications					
EN ISO 2560-A			AWS A5.1		
E 42 4 B 4 2			E7015		
Characteristics and typical fields of application					
Basic coated stick electrode with good welding characteristics. Smooth and stabile arc. 115 % weld metal recovery; cold toughness down to – 40°C (–40°F). Specially designed for welding of fine grained steels and fine grained structural steels, for boiler plates, tank construction and ship building.					
Base materials					
Boiler steels P235GH, P265GH, P295GH, P355GH S235JRG2 – S355J2, E335 fine grained structural steel up to S420N Pipeline steels P235, P265; X42 – X60.					
Typical analysis of all-weld metal					
	C		Si		Mn
wt-%	0.06		0.5		1.2
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–30 °C
aw	420	510	22	120	47
sr	380	490	27	130	47
Operating data					
	Polarity: DC +	Redrying: 250 – 350 °C / 2 h (482 – 662 °F)	ø mm	L mm	Amps A
			2,5	350	65 – 95
			3,2	350/450	90 – 130
			4,0	350	140 – 180
			5,0	450	190 – 230
Approvals					
DB (10.132.05), CE					