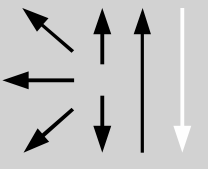


Classifications					
EN ISO 2560-A		AWS A5.1			
E 42 4 B 4 2		E7015			
Characteristics and typical fields of application					
<p>Basic coated stick electrode. The smooth and stabile arc offers good welding characteristics and an easy handling.</p> <p>Specially designed for welding of fine grained steels and fine grained structural steels, for boiler plates, tank construction and ship building.</p> <p>Steels up to a C-content of 0.4 % can be welded safe without cracks.</p> <p>115 % weld metal recovery; cold toughness down to – 40°C (–40°F).</p>					
Base materials					
<p>Boiler steels P235GH, P265GH, P295GH, P355GH S235JRG2 – S355J2, E335 fine grained structural steel up to S420N Pipeline steels P235, P265; X42 – X60.</p>					
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 _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	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					