

ROYAL - 7015 (E 7015)

AWS : A 5.1, E 7015 EN ISO 2560 A E 38 3 B 32 H5

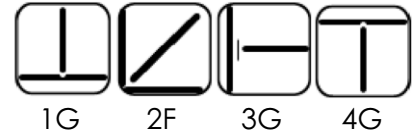
Applications

For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

Characteristics on Usage

A medium heavy coated all position hydrogen controlled electrode for the welding of medium high tensile structural steel such as Carbon steel up to 0.4% C, Manganese steel up to 2.0% Mn, Silicon steel up to 0.5% Cr, Chrome Nickel steel and other heat treated steels where matching of base metal and weld metal is not necessary. Gives radiographic quality welding.

Welding Positions



Notes On Usage

- ⚡ Dry the electrode at 350-400 °C for 60 Min- before use .
- ⚡ Keep the arc as short as possible.
- ⚡ Use wind screen against strong wind

LOW HYDROGEN TYPE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.15 Max	1.25 Max	0.90 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	Hydrogen (Mercury method) in 100gm weld metal
490 Min	400 Min	22 % Min	50 - 80 Joules	5 ml Max

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	DC +ve	60-95
3.15 x 450	5	20		90-120
4.00 x 450	5	20		140-190
5.00 x 450	5	20		190-250
6.30 x 450	5	20		250-310