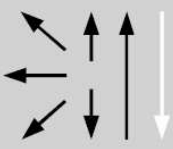


Classifications					
EN ISO 2560-A			AWS A5.1		
E 42 4 B 4 2			E7015		
Characteristics and typical fields of application					
Basic coated stick electrode. The smooth and stabile arc offers good welding characteristics and an easy handling.					
Specially designed for welding of fine grained steels and fine grained structural steels, for boiler plates, tank construction and ship building.					
Steels up to a C-content of 0.4 % can be welded safe without cracks.					
115 % weld metal recovery; cold toughness down to – 40°C (–40°F).					
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					