LEADER - 7015 (E 7015)

AWS : A 5.1, E 7015

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.

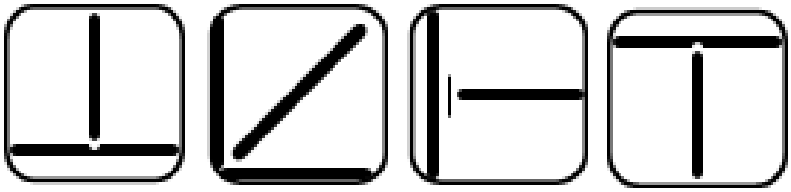
Characteristics on Usage

A midium heavy coated all position hydrogen controlled electrode for the welding of medum 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 radiographjic quality welding.

Notes On Usage

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

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V %
0.15 Max	1.25 Max	0.90 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30 Max	0.08 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	Hydrogen (Mercury method) in 100grm weld metal
490 Min	400 Min	22 % Min	50 - 80 Joules	5 ml (Max)

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 X 350	225	900	DC +ve	60-95
3.15 X 450	130	520		90-120
4.00 X 450	85	340		140-190
5.00 X 450	55	220		190-250
6.30 X 450	30	120		250-310