

ES 7015

SMAW

ESWECO
The Art of Welding

Type Sodium-Basic

E7015

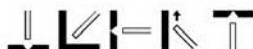
Description

ES 7015 is a carbon steel electrode with low-hydrogen sodium type coating. DCRP (Direct Current Reversed Polarity). All-position welding. It has excellent welding performance, stable arc, low spatters and good slag detachability. The deposited metal has excellent mechanical properties, crack-resistance and low temperature impact roughness.

Application: Used for welding carbon steel and low-alloy steel structures (under pressure and moving loads), such as 16Mn, 09Mn2Si, 09Mn2V and A, B, D and E steel for ships, etc.

Current

AC, DC



Classifications

SFA/AWS A5.1	E7015
ISO 2560-A	E42 3 B 22 H5

Typical all weld metal composition, %

C	Si	Mn
0.08	0.37	1.26

Typical mech. Properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	545
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	155
-30	135

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	450	90-130	24
4.0	450	125-200	25
5.0	450	170-210	25