

**BASIC COATED - LOW HYDROGEN ELECTRODE of E7015**

AWS Code:E10015-G  
EN Code:757-E55 4 Z B T  
ISO Code:18275-B-E6915-G P

**CHARACTERISTICS:**

**E 7015** is a basic coated low hydrogen electrode suitable for welding heavy structures, high tensile strength jobs where impact strength at sub-zero temperatures are required. The basic coated formulation ensures a defect-free radio-graphic quality weld. The superb and well established flux formulation ensure excellent performance of the electrode in DC(+) in all welding positions except vertical down.

**ADVANTAGES:**

- Uniform and soft metal transfer.
- Easy to control weld pool and slag.
- Suitable in DC (+).
- Suitable for difficult to weld steels.
- Neat weld profile in fillet joints.
- High tensile strength and excellent toughness in sub-zero temperatures.
- Suitable for highly restrained joints.

**APPLICATIONS:**

**E 7015** is suitable for all sorts of joining, repairing and fabrication of structural works medium and high tensile steels of grade 550 N/sq mm., The applications include; welding of Structures, highly restrained joints, bridges, railway coaches & wagons, plants, ships, tugs, barges, trawlers, dredgers, storage tanks, boilers, pipelines, grills etc., The electrode can be used as a non-machinable electrode on castings.

**CURRENT CONDITIONS:**

Specification (mm)		2.50×350	3.15×350	4.00×450	5.00×450
Current (A)	DC(+)	70-100	90-140	140-200	190-250

**TYPICAL CHEMICAL COMPOSITION OF WELD METAL**

Element	C	Mn	Si	S	P	Mn+Ni+Cr+V
Percent	0.09	1.00	0.60	0.020	0.020	<1.75

**TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL**

Y.S. N/sq mm	UTS N/sq mm	Elongation %	Redn. In area %	CVN Impact value
460	540	26	75	47J (-20°C)

Diffusible Hydrogen Content : 10 ml/100gms weld.

Radio-graphic evaluation : Meets the requirements of Grade-I.

Moisture content in the flux covering : <2.0%.

Rebaking recommendations : The electrodes should be re-baked at 250°C for 2 hours or 350°C. For one hour prior to use and maintain warm till the job is completed.

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