Stanvac INTERNATIONAL

Product Data Sheet

C-Mn and low-alloy steels — STAVINOX 7015

- Ultra smooth finely rippled weld beads.
- Excellent impact-notch toughness in class.
- Superior reliability for the critical welding of C-Mn micro alloyed & low alloy structural steels.

Classification ***AWS A*5.1:** E 7015 - H4

Description and applications Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Good operating characteristics when positional welding. Excellent for joint access making electrodes suitable for root joint welding. Weld metal has good toughness properties down to -30°C. Suitable for offshore, petrochemicals and power engineering industries.

Base materials S(P)235-S(P)420; GP240-GP280; L245-L360

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	S
0.07	0.30	1.30	0.025	0.020

All weld metal mechanical properties (typical)

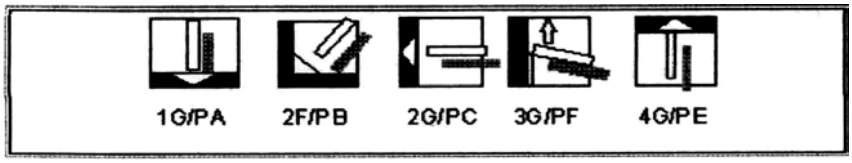
Heat Treatment	Tensile Strength R_m (N/mm^2)	Yield Strength R_m (N/mm^2)	Elongation A_5%	Impact Energy ISO-V(J)- 30°C	Hardness
As welded	550-620	450	30	70	--

Welding recommendations: =+

Amperes (A)

2.50	3.15 /3.20	4.00	5.00
50-80	90-130	130-170	180-220

Storage and Redrying: Keep dry and avoid condensation, HD≤5: Re-dry at 340-360°C for 1 hour, 3 times max.



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