

ROYAL - 7015 (E 7015)

AWS : A 5.1, E 7015

Applications

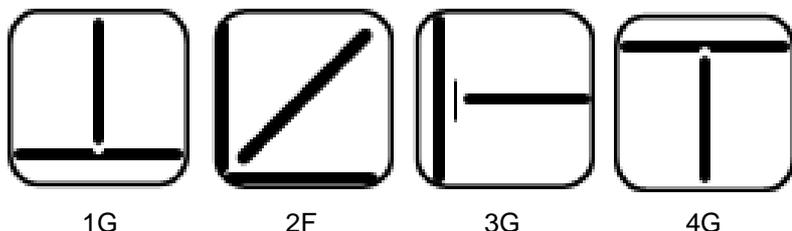
For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

Characteristics on Usage

A medium heavy coated all position hydrogen controlled electrode for the welding of medium 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 radiographic 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**Chemical Composition Of Weld Metal**

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

Mechanical Properties Of Weld Metal

| U.T.S. | Y.S. | ELONGATION | IMPACT (CVN) | Hydrogen (Mercury method) |
|----------------------|----------------------|--------------|------------------|---------------------------|
| (N/mm ²) | (N/mm ²) | (L = 4d) % | AT - 30° C (J) | in 100gm weld metal |
| 490 Min | 400 Min | 22 % Min | 50 - 80 Joules | 5 ml (Max) |

Approvals**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 |