

KE7015.G

Classifications:

AWS A5.5 E7015-G

A5.5M E4915-G

EN ISO 2560-A:E 42 4 B 2 2

EN ISO 2560-B:E4915-G AP

Characteristics and Applications:

KE7015.G is a high strength and high toughness stick electrode used by only DC. Its welding performances in all position are featured by good slag removal, stable arc, less spatter and excellent radiographic test result. It is suitable for the welding of low alloy steels, such as production platform, shipbuilding and high pressure vessels.

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	—	≥1.0	≥0.80	≥0.30	≥0.50	≥0.20	0.03	0.03	≥0.10
KE7015.G	0.070	1.40	0.32	0.03	0.51	0.02	0.019	0.013	0.05

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/°C)
AWS	390	490	22	—
KE7015.G	490	585	28	122 $\bar{}$ -40

Notes on Usage:

1. Dry the stick electrodes at 350°C for one hour before welding.
2. Be sure to remove moisture, oil and rust on the base metal.
3. To avoid blowholes when striking the arc, please use back step method during welding process.
4. Keep short arc length when welding.
5. Current type : DC+ only.

Sizes Available and Recommended Parameters:

Diameter(mm)	2.6x350	3.2x350	4.0x400	5.0x400
Current F.H	55-85	90-130	130-180	180-240
(Amp) OH,V	50-80	90-120	130-160	—

eco weld

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