

Stick electrode for 1-1.25%Cr-0.5%Mo steel

Features: Applied for ASTM A387 Gr.11, Gr.12 and equivalents

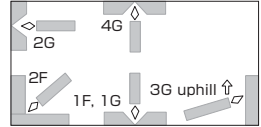
Welding Positions:

Classification: AWS A5.5 E7015-B2L

Redrying Conditions: 325~375°Cx1h

Identification color: 1st Black, 2nd Yellow

Polarity: DCEP

**Packaging data**

| φ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm |
|------|-----------|---------|-----------|---------|--------------------------|
| 2.6 | 300 | 2 | 20 | 18 | 170W, 120H, 330L |
| 3.2 | 350, 400 | 5 | 20 | 31, 36 | 170W, 120H, 380L or 430L |
| 4.0 | 400 | 5 | 20 | 55 | 170W, 120H, 430L |

Composition (all-weld metal mass%)

| | Typical | Guaranty ^a |
|-----------|---------|-----------------------|
| C | 0.02 | 0.05 |
| Si | 0.93 | 1.00 |
| Mn | 0.74 | 0.90 |
| P | 0.01 | 0.03 |
| S | <0.01 | 0.03 |
| Cr | 1.20 | 1.00~1.50 |
| Mo | 0.52 | 0.40~0.65 |

Note: ^aSingle values are maximum.

Welding parameters (A)

| φ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|------|----------------|---------------|
| 2.6 | 70~100 | 60~90 |
| 3.2 | 110~140 | 100~130 |
| 4.0 | 150~180 | 120~160 |

All-weld mechanical properties

| | Typical | Guaranty |
|---------------------|---------|----------|
| 0.2%YS (MPa) | 470 | 393min. |
| TS (MPa) | 580 | 518min. |
| El on 4d (%) | 29 | 19min. |
| IV 0°C (J) | 78 | - |
| PWHT (°Cxh) | 690x1 | 690±15x1 |

Approvals

| LR | MG (E7015-B2L) |
|----|----------------|
| | |