

7027

CATEGORY SMAW Stick Electrodes

TYPE High efficiency electrode with approximately 150% metal recovery with basic mechanical properties..

APPLICATIONS Wagon building, shipbuilding, general construction, heavy machinery, vessel, containers

PROPERTIES The 7027 is a high performance electrode with a thick coating and a recovery of 150%. For welding heavy machinery, body and wagon building as well as in the fabrication of vessels and containers and in shipbuilding. Moreover this electrode is ideally suited for primer treated or rusty materials and offers excellent impact properties down to -40°C. The 7027 has a high current carrying capacity and self detaching porous slag (excellent for narrow gabs where the slag is often hard to remove).

CLASSIFICATION

AWS	A 5.1:E 7027
EN ISO	2560-A: E 42 4 RA 53 2560-B: E 49 27 A
DIN	1913: E 51 53 AR 11 160

SUITABLE FOR	Steel types:	DIN:	W.Nr:
	Unalloyed steels	St 33 to St 52.3	1.0035, to 1.0561
	Boiler steels	HI, HII, 17Mn4	1.0345, 1.0425
	Finegrained steels	StE 255 to StE 355	-
	Shipbuilding plates	A, B, D	1.0440, 1.0472
	-	-	1.0475
	Steel castings	GS-38 to GS-52	1.0416

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	P	S
0.07	1.0	0.30	<0.025	<0.025

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW:	>420	500-640	>22	>75	>47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) AC/DC-/+	kg / can	kg / 6pack	kg / 1000
3.2	450	120-160	3.2	19.2	65
4.0	450	160-220	3.2	19.2	94
5.0	450	220-320	3.3	19.8	147
6.0	450	300-400	3.3	19.8	205

REDRYING TEMPERATURE 100-110°C / 1hr