

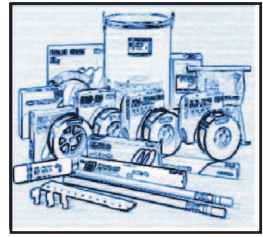
Shielded Metal Arc Welding

ANU BOND- 7015 (E 7015)

AWS: A 5.1, E 7015

Application :

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 as Carbon steel up to 0.4% **C**, Manganese steel up to 2.0% **Mn**, Silicon steel up to 0.5% **Cr**, Chromium Nickel steel and other heat treated steel where matching of base metal and weld metal is not necessary. Gives radiographic quality welding.

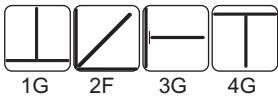
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.15 Max	1.25 Max	0.95 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30 Max	0.08 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Y. S. (N/mm ²)	Elongation (L=4d) %	Impact (CVN) AT +27 ⁰ C (J)	Hydrogen(Mercury method) in 100gm weld metal
490Min	400 Min	22 % Min	50-80 Joules Min	5 ml (Max)

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg Per Packet	Kg 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

