BASIC COATED SODIUM TYPE ELECTRODE

SMAW

PAK BRIDGE E-7015

PAK BRIDGE ®©
A PRODUCT OF SHANGHAI INDUSTRIES

KEY FEATURES

1. UNIFORM AND SOFT METAL TRANSFER.
2. EASY TO CONTROL WELD POOL AND SLAG.
3. SUITABLE IN AC, DCEP OR DCEN.
4. INCREASED WELD DEPOSIT ENSURES FASTER WELDING.
5. NEAT WELD PROFILE IN FILLET JOINTS.
6. HIGH TENSILE STRENGTH AND EXCELLENT TOUGHNESS IN SUB-ZERO TEMPERATURES.
7. SUITABLE FOR HIGHLY RESTRAINED JOINTS
8. DIAMETERS: 3/32", 1/8", 5/32", 3/16"

CLASSIFICATION

AWS A5.1 E7015, ISO 2560-A E42 3 B22 H5, GB/T 5117 E5015

GENERAL DESCRIPTION

Pak Bridge E-7015 is a low alloy steel welding electrode covered with sodium low hydrogen type coating. DC is applied and the electrode should be contacted reverse polarity. Pak Bridge E-7015 has excellent plascticity, tenacity and anti cracking ability in low temprature, good arc stifness, nearly no magnetic below. It can offer good minor parts in welding with very few splashes and easy slaging and stable electric arc.

APPLICATIONS

Pak Bridge E7015 is applied in welding 490 Mpa grade carbon steel and low alloy steel such as 16Mn, and welding grade A,B,D,E steel for shipyard primary components, boiler, pressure vessels, pipe lines, and other important steel structure components.

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD META L

C	Mn	Si	S	P
≤0.060	≤0.96	≤0.52	≤0.010	≤0.020

MECHANICAL PROPERTIES, OF DEPOSITED METAL

Item	Tensile Strength	Yield Strength	Elongation	Charpy V Impact-30°C
Units	N/mm^2	N/mm^2	%	J
General Result	≥460	≥560	≤28	125

ELECTRODE SIZE / CURRENT CONDITION / PACKAGING INFORMATION

Electrode Dia (mm)		2.5mm	3.2mm	4.0mm	5.0mm
Electrode length (mm)		300mm	350mm	400	400
Current Range	Min.	60A	80A	110A	160A
	Max.	100A	140A	210A	230A
Packing Information Inner Box Weight (No of PKT) Per Carton		2.5kg(8)	5kg(4)	5kg(4)	5kg(4)
Approx. Electrodes Per Pkt.		140	126	84	51

STORAGE AND RE-BAKING

It is recommended that the Pak Bridge E-7015 electrodes are strored in a dry heated store in a minimum temperature of 18°C, and a maximum relative humidity of 60%. Not more than 6 cartons should be staked on top of one another to avoid damage to the coatings.

Note:

Before using the electrode must be preheated at the temperature of 350°C for 1 hour.
The impurities such as rust, oil staiins and mositure must be cleared off the work piece.
Short arc is required to perform weldings.
Narrow weld path is preferred.

WELDING POSITIONS