

Classifications

EN ISO 2560-A	AWS A5.1 / SFA-5.1
E 42 4 B 4 2	E7015

Characteristics and typical fields of application

Basic coated stick electrode. The smooth and stabile arc offers good welding characteristics and an easy handling. Specially designed for welding of fine grained steels and fine grained structural steels, for boiler plates, tank construction and ship building.

Steels up to a C-content of 0.4% can be welded safe without cracks.
115% weld metal recovery; cold toughness down to -40°C.

Base materials

Steels up to a yield strength of 420 MPa (60ksi)
Boiler steels P235GH, P265GH, P295GH, P355GH
S235JRG2 – S355J2, E335
fine grained structural steel up to S420N
Pipeline steels P235, P265; X42 – X60.


Typical analysis

	C	Si	Mn
wt.-%	0.06	0.5	1.2

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J	
	MPa	MPa	%	20°C	-40°C
u	420	510	22	120	47
s	380	490	27	130	47

Operating data

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	FOX K 50 / E 42 4 B / E7015	2.5 × 350	65 – 95
	Redrying	250-350°C/2h	3.2 × 350	90 – 130
			3.2 × 450	90 – 130
			4.0 × 350	140 – 180
			4.0 × 450	140 – 180
		5.0 × 450	190 – 250	

Approvals

DB (10.014.96), CE