

AK E7015

Description: AK-E7015 is a basic carbon steel electrode. It adopts DC reverse connection and can be welded in all positions. It has excellent plasticity, toughness and crack resistance.

Application: Mainly used for low carbon steel, medium carbon steel and low alloy steel, such as 16Mn, 09 Mn2Si and ship A, B, D, E grade steel plates for the main components of ships, as well as boilers, pressure vessels, vehicles, buildings, bridge dyeing, etc. Welding of important structural parts.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	
Requirement	0.15	0.9	1.6	0.035	0.040	0.30	0.30	0.20	
Actual Result	0.075	0.51	1.26	0.012	0.015	0.010	0.028	0.027	

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	490-660	≥400	≥ 22	≥47J(-30℃)
Actual Result	550	446	27	130

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current/A	F/ H	70-110	100-140	140-180
	V/OH	50-80	80- 110	130- 170