

# SM-7015

## CLASSIFICATIONS :

AWS A5.1 E7015

ASME SFA A5.1 E7015

## SMAW ELECTRODE - MILD STEEL, LOW HYDROGEN

### DESCRIPTION

SM-7015 is all-position electrode and usually are suitable for welding in the vertical welding position with either the upward or downward progression.

### FEATURES

Smoother arc transfer, Easier slag removal, Less Spatter.

Excellent usability in all positions welding including vertical down.

Suitable for butt and fillet welding of thin plates/sheets.

Smooth and bright weld seams, Smoother with a finer ripple bead surface.

Stable arc on AC and DC.

### APPLICATIONS

It is especially suitable for nuclear power stations, petroleum chemical plants, and heavy steel plates.

Maintenance or repair welding.

### CHEMICAL COMPOSITION

	%C	%Mn	%Si	%P	%S
Requirements	0.15 max	1.25 max	0.9 max	0.035 max	0.035 max
Typical Results	0.04	0.6	0.26	0.02	0.01
	%Ni	%Cr	%Mo	%V	Comb. Limit
Requirements	0.30 max	0.20 max	0.30 max	0.08 max	1.5 max
Typical Results	0.03	0.03	0.003	-	0.14

### MECHANICAL PROPERTIES

	Tensile Strength, Mpa	Yield Strength, Mpa	Elongation, %
Requirements	490 min	400 min	22 min
Typical Results	530	435	32.5

### OPERATING PROCEDURES

Polarity	Current (Amps)				
	Ø2.0 mm	Ø2.6 mm	Ø3.2 mm	Ø4.0 mm	Ø5.0 mm
AC	50 - 80	75 - 115	110 - 140	160 - 200	205 - 260
DC ±	45 - 75	70 - 105	100 - 135	145 - 180	185 - 235

### WELDING POSITION



### NOTE

Electrodes that have become damp should be re-dried at 300-350 °C for 1 hour before welding, do not dry twice to avoid detachment of covering.