

## Stick electrode for 1-1.25%Cr-0.5%Mo steel

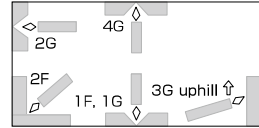
**Features:** Applied for ASTM A387 Gr.11, Gr.12 and equivalents

**Classification:** AWS A5.5 E7015-B2L

**Redrying Conditions:** 325~375°Cx1h

**Identification color:** 1st Black, 2nd Yellow

**Polarity:** DCEP

**Welding Positions:****Packaging data**

$\phi$ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	170W, 120H, 330L
3.2	350, 400	5	20	31, 36	170W, 120H, 380L or 430L
4.0	400	5	20	55	170W, 120H, 430L

**Composition (all-weld metal mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.02	0.05
<b>Si</b>	0.93	1.00
<b>Mn</b>	0.74	0.90
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	1.20	1.00~1.50
<b>Mo</b>	0.52	0.40~0.65

Note: <sup>a</sup>Single values are maximum.

**Welding parameters (A)**

$\phi$ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	60~90
3.2	110~140	100~130
4.0	150~180	120~160

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	470	393min.
<b>TS (MPa)</b>	580	518min.
<b>El on 4d (%)</b>	29	19min.
<b>IV 0°C (J)</b>	80	-
<b>PWHT (°Cxh)</b>	690x1	690±15x1

**Approvals**

LR	MG