

Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 38 3 Z 1 NiCu B 4 2	E 4915-GA	E7015-G	E4915-G

Characteristics and typical fields of application

Basic covered NiCu alloyed special electrode.
For the welding of weathering and fine grained structural steels.

Base materials

S235J0W, S235J2W, S355J2G1W, such as for example
COR-TEN A, COR-TEN B, Patinax 37 etc.; ASTM A36, A283 Gr. B, C

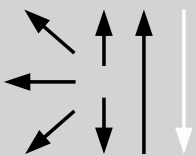
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Ni	Cu
wt-%	0.05	0.30	0.65	0.60	0.40

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
aw	390	480	22	150
sr	370	450	27	160

Operating data

	Polarity: DC (+)	Redrying: 250 – 350 °C / 2 h (482 – 662 °F)	ø (mm) 3.2 4.0	L mm 350 450	Amps A 90 – 140 140 – 190
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Store dry.

Approvals

TÜV (01600), DB (10.132.24)