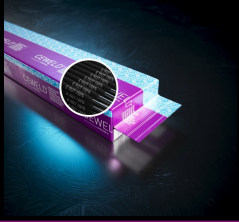


CEWELD E 7027

TYPE	Highly efficient rutile-acid electrode with a yield of approx. 160 %. (Type E 42 2 RA, E 7027)						
APPLICATIONS	CEWELD® E 7027 is a highly efficient electrode with a yield of approx. 160 % and the mechanical properties of a basic electrode. It is used for welding heavy machinery, in car body and wagon construction as well as in tank and shipbuilding.						
PROPERTIES	CEWELD® E 7027 is ideal for primed or rusty materials and offers excellent notch impact properties down to -20°C. CEWELD® E 7027 has a high current carrying capacity and a self-releasing porous slag (excellent for narrow crevices where slag is often difficult to remove).						
CLASSIFICATION	AWS	A 5.1: E 7027					
	EN ISO	2560-A: E 42 2 RA 53					
	F-nr	1					
	FM	1					
SUITABLE FOR	Rp< 420 MPa (60ksi) ISO 15608: 1.1(ReH < 275 MPa), 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 420 MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60(Root X 80)						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S		
	0.07	0.3	1	0.025	0.025		
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-20°C	
	As Welded	450	550	25	95	85	HRc
REDRYING	140°C / 1 hr						
CURRENT TYPE:	AC, DC+/-						
GAS ACC. EN ISO 14175							



CEWELD E 7027

E 7027 2,5 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720682051207

E 7027 3,2 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050798

E 7027 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682050804

E 7027 5,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,6	8720682050811