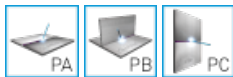
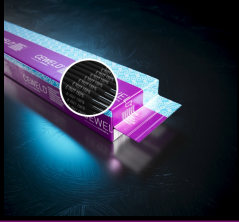


# CEWELD E 7027

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                         |                      |                    |                         |       |          |
|---------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|-------|----------|
| 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                                | <b>Rp&lt; 420 MPa (60ksi) ISO 15608: 1.1( ReH &lt; 275 MPa ), 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 420 MPa)</b><br>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<br>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL<br>A, B, D<br><b>ASTM</b> 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 <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |