

7027

CATEGORY	SMAW Stick Electrodes						
TYPE	High efficiency, rutile acid electrode with approximately 150% metal recovery.						
APPLICATIONS	Wagon building, shipbuilding, general construction, vessel, containers						
PROPERTIES	<p>The 7027 is a high performance electrode with a thick rutile acid coating and a recovery of 150%. For welding in mechanical engineering, body and wagon building as well as in the fabrication of vessels and containers and in shipbuilding.</p> <p>Moreover this electrode is ideally suited for primer treated or rusty materials. The 7027 has a high current carrying capacity and self detaching porous slag (excellent for narrow gabs where the slag is often hard to remove).</p>						
CLASSIFICATION	AWS	A 5.1:E 7027					
	EN ISO	2560-A: E 42 4 RA 53					
		2560-B: E 49 27 A					
	DIN	1913: E 51 53 AR 11 160					
SUITABLE FOR	Steel types:	DIN:	W.Nr:				
	Unalloyed steels	St 33 to St 52.3	1.0035, to 1.0561				
	Boiler steels	HI, HII,17Mn4	1.0345, 1.0425				
	Finegrained steels	StE 255 to StE 355	-				
	Shipbuilding plates	A, B, D	1.0440, 1.0472				
	-	-	1.0475				
	Steel castings	GS-38 to GS-52	1.0416				
APPROVALS	TUV, LR, CE approved						
WELDING POSITIONS:							
	C	Mn	Si	Cr	Ni	Mo	
	0.08	1.0	0.30		-	-	
MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW:	>420	500-650	>22	>75	>47		
AW: as welded							
WELDING PARAMETERS PACKING							
Welding Parameters				Packing			
D (mm)	Length (mm)	Current (A) AC/DC-/+		kg / can	kg / 6pack	kg / 1000	
3.2	450	120-160		3.2	19.2	65	
4.0	450	160-220		3.2	19.2	94	
5.0	450	220-320		3.3	19.8	147	
6.0	450	300-400		3.3	19.8	205	
REDRYING TEMPERATURE	100-110°C / 1hr						