








CEWELD E 7027

TYPE	High efficiency electrode with approximately 150% metal recovery with basic mechanical properties..						
APPLICATIONS	Wagon building, shipbuilding, general construction, heavy machinery, vessel, containers						
PROPERTIES	CEWELD E 7027 is a high performance electrode with a thick coating and a recovery of 150%. For welding heavy machinery, body and wagon building as well as in the fabrication of vessels and containers and in shipbuilding. Moreover this electrode is ideally suited for primer treated or rusty materials and offers excellent impact properties down to -40°C. CEWELD E 7027 has a high current carrying capacity and self detaching porous slag (excellent for narrow gabs where the slag is often hard to remove).						
CLASSIFICATION	AWS	A 5.1: E 7027					
	EN ISO	2560-A: E 42 2 RA 73					
	F-nr	1					
	FM	1					
SUITABLE FOR	Reh ≤ 420 MPa ISO 15608: 1.1, 1.2 1.0426, 1.0429, 1.0481, 1.0484, 1.0409, 1.0421, 1.0430, 1.0436, 1.0473, 1.0482, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.05821.8902, 1.8912, 1.8932, 1.8972, 1.8900, 1.8910, 1.8930 S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210-L415NB, L290MB - L415MB, P355T1, P235T2 - P355T2, P235G1TH, P255G1TH (Root L480MB) API Spec. 5 L: Grade A, B, X42, X 46, X 52, X 56, X 60, (Root X 70)						
APPROVALS	CE						
WELDING POSITIONS	<div>PAPBPCPDPF</div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S		
	0.07	0.3	1	0.025	0.025		
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)	RT	Impact Energy (J) ISO-V	
	As Welded /	450	550	25	95	-20°C	-40°C
						85	60
REDRYING TEMPERATURE	140°C / 1 hr						
GAS ACCORDING EN 14175							



CEWELD E 7027

E 7027 2,0 X 300MM

Type	KG/unit	EANCode
Can	2	8720663400741

E 7027 2,5 X 350MM

Type	KG/unit	EANCode
Can	2,4	8720663400758

E 7027 3,2 X 450MM

Type	KG/unit	EANCode
Can	3,2	8720663400765

E 7027 4,0 X 450MM

Type	KG/unit	EANCode
Can	3,2	8720663400772

E 7027 5,0 X 450MM

Type	KG/unit	EANCode
Can	3,3	8720663400789