



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, X56, X60, X65 (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	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	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