

7016

CATEGORY	SMAW Stick Electrodes
TYPE	Double coated semi basic electrode with excellent arc stability
APPLICATIONS	Repair welding, root runs, vessel, shipbuilding, construction buildings, fences, bridges
PROPERTIES	<p>Double-coated semi basic CTOD tested electrode with excellent welding properties in difficult positions and high mechanical properties. It is particularly suited for poor welding machines with low open voltage on AC and DC+. Excellently suited for old and rusty material because of its stable and intensive arc. Well suited for root runs and in the maintenance and repair sector due to its absolute insensitiveness for rust or diluted base metals.</p> <p>Hydrogen content: <10ml/100gr weld metal.</p>

CLASSIFICATION	AWS	A 5.1: E 7016
	EN ISO	2560-A: E 42 4 B 12 H10 2560-B: E 49 16 A
	DIN	1913: E 51 43 B R 10

SUITABLE FOR	Base metal	DIN	EN	ASTM
	Shipbuilding	A, B, D, AH 32 till EH 36	-	A 131 / A 106
	Un alloyed steel	St 33, St 37-2, St 52-3	P235GH, P265GH, P295GH	A 515 / A 715 A 283 / A 285
	Boiler steels	HI, HII, 17Mn4	-	A 414 / A 662
	-	-	-	A 372 / A 369
	Pipe steels	St 35.8, St 45.8	P235T1/T2 - P355N	A 210 / A 516
	-	StE 210.7TM - StE 380.7TM	L210 - L380	A 255 / A 333
	Fine grain steels	StE 255 till StE 355	S255, S355, S420	A 350 / A 612
	API steels	X42	X42	
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	W.Nrs:			
		1.0035 to 1.0570, 1.0461 to 1.0562, 1.462 to 1.0565, 1.0345, 1.0425, 1.0481, 1.0308 to 1.0581, 1.0307 to 1.0582, 1.0440, 1.0472, 1.0475, 1.0476, 1.0416 to 1.0551		

APPROVALS	TUV, CE approved
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WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
0.05	1.0	0.65	-	-	-

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	510-640	>22	>47			

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2,5	350	65-90	2.4	14,4	19.6	
3,2	350	90-140	2.4	14.4	32.8	
4,0	450	140-185	3.0	18	66.7	
5,0	450	180-240	3.0	18	100	

REDRYING TEMPERATURE 380°C / 1hr

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