



7016 E

AWS A 5.1: E7016 ISO 2560: E 38 3 B 12 H10

DESCRIPTION

Rutile-basic double coated electrode with low hydrogen and outstanding welding characteristics. Stable arc in all positions that makes it optimal for root passes and badly prepared joints too. Universal use for all construction steels and repairs. A favourite electrode to use in well drilling operations.

WELDING POSITIONS



CURRENT

DC+/DC-(AC)

COATING

Rutile-Basic

MATERIAL

Construction steel, pipework, shipping, pressure vessels

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
550	450	27	+20°C 150 - 20°C >80 - 50°C >70

WELD METAL COMPOSITION(%)

C	Mn	Si	S	P
0.10	0,9	0,7	<0,02	<0,02

PACKAGING & WELDING PARAMETERS

Dimension	2,0 x 300	2,5 x 350	3,2 x 450	4,0 x 450	5,0 x 450
Item code	8M70162002	8M70162502	8M70163202	8M70164002	8M70165002
Current(A)	40-70	60-90	90-140	130-180	180-240

EQUIVALENT FILLER METALS

TIG	Meltolit SG3
MAG	Meltolit SG2, SG3, EVO2, EVO3, NW3
FCW	Megafil 710M, Megafil 713R

Redrying if necessary for 2 hours in 300°C.