

S-7016.0

Type : Basic

Conformances

AWS A5.1/ ASME SFA5.1 E7016
 JIS Z3211 E4316
 EN ISO 2560-A-E42 2 B 1 2
 KR 3H10, 3YH10
 ABS 3H10, 3Y
 LR 3YH15
 DNV 3YH10
 NK KMW53HH

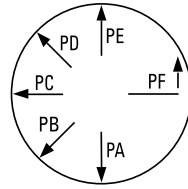
Applications

- Pipe line

Features

- Suitable for one side welding of pipe
- Stable arc
- Relatively low current

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X
 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	√	
3.2 (1/8)	350 (14)	√	
4.0 (5/32)	400 (16)	√	
5.0 (3/16)	400 (16)	√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.45	1.10	0.015	0.007

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
489 (70,905)	566 (82,070)	29.6	-30 (-22)	109 (80)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	400 (16)	400 (16)
F	60~90	90~130	130~190	180~240
FV-up, OH	50~80	80~120	110~180	150~210
Root pass	30~65	60~110	90~150	130~180