

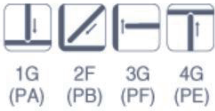
E7016

AWS A5.1 E7016
 ISO2560-A E42 3 B 1 2
 GB/T5117 E5016

Description:

A low hydrogen alkaline electrode for all positional welding with excellent welding properties, like good slag detachability and beautiful weld appearance, suitable for short arc welding. Used to weld the Marine steels (A、B、D、E、AH36、DH36、EH36) and other same grade strength structures, like vehicles, bridges and constructions etc.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	550
Yield strength(MPa):	446
Elongation(%):	28
Impact values(≥ 47)/(-30°C):	120

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.068	1.13	0.018	0.008	0.51	0.007	0.018	0.008	0.015

Welding Current: (AC/DC+)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	F/H 70-110	100-140	140-180	180-230
Current/A	V/OH 50-80	80-110	130-170	-

Note:

- 1.The electrodes must be baked 1-2 hours in 350°C-450°C before using.
2. Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.