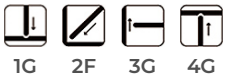
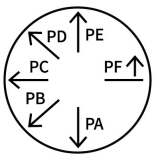
S-7016.HR

Classification

AWS A5.1/ ASME SFA-5.1 E7016 H4R
A5.1/ ASME SFA-5.1 E7016-1 H4R
JIS Z 3211 E4916 H5
EN ISO 2560-A E42 3 B 1 2 H5
KS D7006 E5016

Welding Positions





Features

- Extra low hydrogen electrode
- Good mechanical properties
- Vacuum sealed package available (HDM ≤ 4ml/100g)

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Redrying Conditions

350~400°C (662~752°F) X 0.5~1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.37	1.11	0.019	0.005

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
499(72)	600(87)	30	-45(-50)	88(65)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	55-85	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-130	80-120	
4.0(5/32)	400(16)	130-180	110-170	
5.0(3/16)	400(16)	180-240	150-200	
6.0(15/64)	450(18)	250-310	-	