

Pipeweld 7016

Basic thin coated AC/DC electrode providing excellent mechanical properties. This electrode ensures fully penetrated root passes, even in adverse conditions. Low moisture content of the coating has a high resistance to moisture re-absorption.

Specifications

Classifications	SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 1 2 H5
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Welding Current	AC, DC+(-)
Diffusible Hydrogen	< 4.0 ml/100 g
Alloy Type	Carbon manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	470 MPa (68 ksi)	550 MPa (80 ksi)	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-45 °C (-49 °F)	150 J (111 ft-lb)
As Welded	-50 °C (-58 °F)	140 J (104 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.25	0.50

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate @ 90% I max
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-140 A	22 V	61 %	52.0	53 sec	1.3 kg/h (2.9 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	110-180 A	22 V	64 %	34.0	62 sec	1.7 kg/h (3.7 lbs/h)