

SUNTHERM 7016

Low Hydrogen Electrode



CLASSIFICATION

IS 814-04 : EB 5426H3X
AWS/A 5.1 : E 7016

CHARACTERISTICS

A basic coated specially designed for welding of medium and high tensile ship steels of grade A, D and E. Typical hydrogen content is 4ml/100 grams of weld deposit. Radiographic quality welds, excellent ductility and notch toughness down to minus 30°C are some special features.

APPLICATIONS

Joining of Mild steel with Cast Iron, welding of HT52W and high tensile grade steels, also used as buffer layer before hard facing.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.076	1.00	0.43	0.019	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	Impact (CVN) at 0° C
464.0 N/mm ²	568.0 N/mm ²	26.40%	68.40%	52 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC 70 V or DC (+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Ready the electrodes at 350°C for one hour or at 250°C for two hours. Use short arc to get to optimum results.