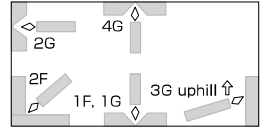


## Stick electrode

<b>Features:</b>	▪ Better impact value
<b>Classification:</b>	AWS A5.1 E7016
<b>Redrying Conditions:</b>	350~400°Cx1h
<b>Identification color:</b>	1st Red, 2nd White
<b>Polarity:</b>	AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	450	5	20	96	170W, 105H, 480L
6.0	450	5	20	141	170W, 105H, 480L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.15
<b>Si</b>	0.57	0.75
<b>Mn</b>	1.06	1.60
<b>P</b>	0.012	0.035
<b>S</b>	0.005	0.035
<b>Ni</b>	0.01	0.30
<b>Cr</b>	0.02	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	<0.01	0.08
<b>Others<sup>b</sup></b>	1.09	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	150~200
6.0	250~310	-

## All-weld mechanical properties

	Typical (AC)		Guaranty	
<b>0.2%YS (MPa)</b>	500	430	400min.	370min.
<b>TS (MPa)</b>	580	530	483min.	480min.
<b>El on 4d (%)</b>	31	33	22min.	25min.
<b>IV -29°C (J)</b>	120	150	27min.	27min.
<b>PWHT (°C×h)</b>	AW	620x1	AW	620±15x1

## Approvals

NK	KMW53, H10