

Stick electrode

Features: ■ Suitable for butt and fillet welding of 520MPa high tensile steel

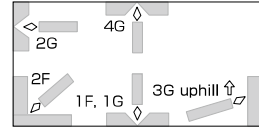
Classification: AWS A5.1 E7016

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Blue, 2nd Brown

Polarity: AC, DCEP

Welding Positions:



Packaging data

| φ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm |
|------|-----------|---------|-----------|---------|------------------|
| 2.6 | 350 | 5 | 20 | 20 | 170W, 125H, 380L |
| 3.2 | 350 | 5 | 20 | 31 | 170W, 120H, 380L |
| 4.0 | 400 | 5 | 20 | 55 | 170W, 110H, 430L |
| 5.0 | 450 | 5 | 20 | 97 | 170W, 105H, 480L |
| 6.0 | 450 | 5 | 20 | 138 | 170W, 105H, 480L |

Composition (all-weld metal mass%)

| | Typical (AC) | Guaranty ^a |
|---------------------------|--------------|-----------------------|
| C | 0.08 | 0.15 |
| Si | 0.64 | 0.75 |
| Mn | 0.81 | 1.60 |
| P | 0.011 | 0.035 |
| S | 0.003 | 0.035 |
| Ni | 0.01 | 0.30 |
| Cr | 0.03 | 0.20 |
| Mo | 0.17 | 0.30 |
| V | 0.01 | 0.08 |
| Others^b | 1.03 | 1.75 |

Note: ^a Single values are maximum.

^b Combined Limit for Mn+Ni+Cr+Mo+V

Welding parameters (A)

| φ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|------|----------------|---------------|
| 2.6 | 50~85 | 50~80 |
| 3.2 | 90~130 | 80~115 |
| 4.0 | 130~180 | 110~170 |
| 5.0 | 180~250 | 150~200 |
| 6.0 | 250~310 | - |

All-weld mechanical properties

| | Typical (AC) | | Guaranty | |
|---------------------|--------------|-------|----------|-----------|
| | | | | |
| 0.2%YS (MPa) | 530 | 470 | 400min. | 400min. |
| TS (MPa) | 610 | 540 | 483min. | 500min. |
| EI on 4d (%) | 31 | 32 | 22min. | 25min. |
| IV -29°C (J) | 100 | 130 | 27min. | 27min. |
| PWHT (°C×h) | AW | 620x1 | AW | 620±15x10 |