

Stick electrode

- Features:**
- Suitable for one-side welding
 - Good arc stability in one-side welding with relatively low current
 - Good impact values down to -60°C

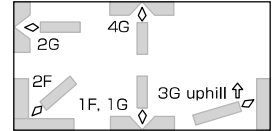
Classification: AWS A5.5 E7016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st White, 2nd Pink

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, 110H, 380L
3.2	400	5	20	35	170W, 105H, 430L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty ^a
C	0.06	0.10
Si	0.62	0.30~0.90
Mn	1.25	1.00~1.60
P	0.02	0.03
S	<0.01	0.03
Ni	0.50	0.30~0.70
Ti	0.01	-
B	0.003	-

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G	Root pass ^b
2.6	60~90	50~80	30~80
3.2	90~130	80~120	60~110

Note: ^b DCEN is also suitable

All-weld mechanical properties

	Typical (DCEP)		Guaranty
0.2%YS (MPa)	510	500	393min.
TS (MPa)	600	590	483min.
EI on 4d (%)	32	33	22min.
IV -60°C (J)	60	55	27min.
PWHT (°Cxh)	AW	620x1	AW & 620±15x1

Approvals

ABS	5Y400 H10
LR	5Y40m (H10)
DNV-GL	5Y40 H10
BV	5Y40 H10