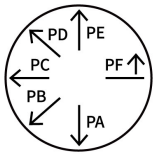


S-7016.LF

Classification

- AWS** A5.1/ASME SFA-5.1 E7016
JIS Z 3211 E4916
EN ISO 2560-A E42 3 B 1 2
KS D7006 E5016

Welding Positions



Features

- Suitable for butt and fillet welding of heavy structure
- Good crack resistance and X-ray performance
- Good mechanical properties
- Low fume

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.62	1.29	0.016	0.007

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
550(80)	605(88)	29	-30(-20)	68(50)

SAW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	55-85	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-130	80-120	
4.0(5/32)	400(16)	130-180	110-170	
5.0(3/16)	400(16)	180-240	150-200	
6.0(15/64)	400(18)	250-310	-	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux