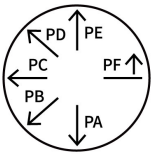


S-7016.LS

Classification

AWS A5.5/ASME SFA-5.5 E7016-G H4R
JIS Z 3211 E4916-N1 AP L
EN ISO 2560-A E46 6 1Ni B 1 2
KS D7023 DL5016-6AP1

Welding Positions



Features

- Extra low hydrogen electrode
- Good impact value at -60°C
- CTOD properties at -10°C (14°F) temperature

Polarity

AC or DC +

Application Areas

- Low temperature strength steel
- Offshore structure
- LPG, LNG storage tank

Redrying Conditions

350~400°C (662~752°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	RS
✓	✓	✓	✓	✓	✓

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

C	Si	Mn	P	S	Ni	Ti	B
0.06	0.37	0.99	0.014	0.006	0.76	0.02	0.003

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
508(74)	597(87)	28	-45(-50) -60(-75)	90(66) 68(50)

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)	450(18)	250-310	-	

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux