

S-7016.M

Classification

- AWS

A5.1/ASME SFA-5.1 E7016
- JIS

Z 3211 E4316
- EN

ISO 2560-A E42 2 B 1 2
- KS

D7004 E4316

Welding Positions



Features

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

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	KR	NK
✓	✓	✓

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

C	Si	Mn	P	S
0.10	0.46	1.01	0.018	0.006

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
453(66)	620(90)	32	-20(0)	111(82)

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	80-130	
4.0(5/32)	400(16)	130-180	110-170	
5.0(3/16)	400(16)	180-240	160-210	
6.0(15/64)	400(18)	250-310	-	

SAW

GMAW

GTAW

FCAW

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