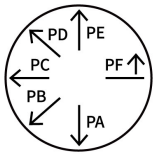


S-7016.O

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 one side welding of pipe
- Stable arc
- Relatively low current

Polarity

AC or DC +

Application Areas

- Pipeline

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS	DNV	KR	LR	NK	CE
✓	✓	✓	✓	✓	✓

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

C	Si	Mn	P	S
0.10	0.41	1.05	0.015	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)
518(75)	611(89)	30	-20(0) -30(-20)	115(85) 90(66)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32) 3.2(1/8) 4.0(5/32) 5.0(3/16)	350(14)	60-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
	350(14)	90-130	80-120	
	400(16)	130-180	110-180	
	400(16)	180-240	150-210	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux