

Brand Name & Classification

AWS/ASME SFA-5.1: E 7016
DIN 1913: E 51 43 B (R) 10
EN 499: E 38 2 B 12 H 10

Approvals Grade

Properties

Multi purpose electrode suitable for assembly work, workshop and repair welding. Smooth and clean welds, blending into the base metal without undercut. Excellent gap bridging properties. Welds are of X-ray quality

Application

Unalloyed structural steel: St33 to St52-3
Boiler plates: HI, HII, 17Mn4
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355
Shipbuilding steels: A, B, D, E, AH 32 to EH 36
Cast steel: GS-38 to GS-52

Weld Metal Analysis Typical values

Carbon: 0.06

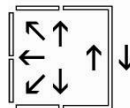
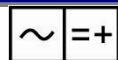
Silicon: 0.70

Manganese: 0.90

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>380 N/MM2	470 – 600 N/mm2	> 26 %	150 J at +20 ⁰ c
			100 J at -20 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400/450	90-140
4.0	400/450	140-190
5.0	400/450	190-250