

# Pipeweld 7016



Basic thin coated AC/DC electrode providing excellent mechanical properties. This electrode ensures fully penetrated root passes, even in adverse conditions. Low moisture content of the coating has a high resistance to moisture re-absorption.

<b>Classifications</b>	SFA/AWS A5.1 : E7016-1 H4 R EN ISO 2560-A : E 42 5 B 1 2 H5
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<b>Welding Current</b>	AC, DC+(-)
<b>Diffusible Hydrogen</b>	< 4.0 ml/100 g
<b>Alloy Type</b>	Carbon manganese
<b>Coating Type</b>	Basic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	470 MPa (68 ksi)	550 MPa (80 ksi)	30 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-45 °C (-49 °F)	150 J (111 ft-lb)
As Welded	-50 °C (-58 °F)	140 J (104 ft-lb)

## Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.25	0.50

## Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-140 A	22 V	52.0	53 sec	61 %	1.3 kg/h (2.9 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	110-180 A	22 V	34.0	62 sec	64 %	1.7 kg/h (3.7 lb/h)