

# SC 7016

Mild steel electrode

## Classification

AWS A5.1: E 7016 - H4

EN 499: E 42 5 B 12 H5

EN ISO 2560-A: E 42 5 B 1 2 H5

## Description and applications

Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Good operating characteristics when positional welding. Excellent for joints Access making electrodes suitable for root joint welding. Weld metal has good toughness properties down to -50°C. Suitable for offshore, petrochemicals and power engineering industries.

- Ultra smooth finely rippled weld beads.
- Less than 4.0 ml diffusible hydrogen.
- Excellent impact notch toughness in class.
- Superior reliability for the critical welding of C-Mn microalloyed & low alloy structural steels.

## Base materials

S(P)235-S(P)420; GP240-GP280; L245-L360.

## All weld metal mechanical properties (typical)

Heat Treatment	Tensile Strength Rm (N/mm <sup>2</sup> )	Yield Strength Rm (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact energy ISO- V (J) -30°C	Hardness
As welded	550-620	450	30	70	--

## Typical weld metal chemical composition (%)

C	Si	Mn	P	S
0.07	0.30	1.30	0.025	0.020

## Amperes (A)

2.50	3.15/3.20	4.00	5.00
50-80	90-130	130-170	180-220

## Storage and redrying

Keep dry and avoid condensation,

HD≤5: Re-dry at 340-360°C for 1 hours, 3 times max.

HD≤10: Re-dry at 300-350°C for 2 hours, 3 times max.

## Welding positions



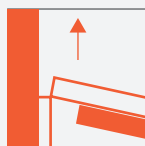
1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

