

## Stick electrode

## Features:

- Suitable for one side welding of pipes
- Extremely good arc stability in one side welding with relatively low current

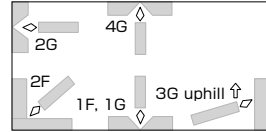
**Classification:** AWS A5.1 E7016

**Redrying Conditions:** 300~350°Cx0.5~1h

**Identification color:** 1st Blue white, 2nd Pink

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	20	170W, 110H, 380L
3.2	400	5	20	35	170W, 110H, 430L
4.0	400	5	20	53	170W, 110H, 430L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.15
<b>Si</b>	0.64	0.75
<b>Mn</b>	0.86	1.60
<b>P</b>	0.012	0.035
<b>S</b>	0.008	0.035
<b>Ni</b>	0.01	0.30
<b>Cr</b>	0.02	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	0.01	0.08
<b>Others<sup>b</sup></b>	0.90	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G	Root pass <sup>c</sup>
2.6	60~90	50~80	30~80
3.2	90~130	80~120	60~110
4.0	130~180	110~170	90~140
5.0	180~240	150~200	130~180

Note: <sup>c</sup> DCEN is also suitable.

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	480	400min.
<b>TS (MPa)</b>	560	483min.
<b>EI on 4d (%)</b>	31	22min.
<b>IV -29°C (J)</b>	80	27min.

## Approvals

<b>ABS</b>	3Y, MG, H10
<b>LR</b>	3Ym, MG, H15
<b>DNV-GL</b>	3Y, H10
<b>BV</b>	3YH10
<b>NK<sup>a)</sup></b>	KMW53, H10
<b>CCS</b>	3Y, H10
<b>NAKS</b>	AWS A5.1 E7016

Note: <sup>a)</sup> AC