

ROYAL – 7016 (W) (E 7016)

AWS : SFA 5.1, E 7016 IS : 814 EB 5426 H3X EN ISO 2560 A E 38 3 B 32 H5

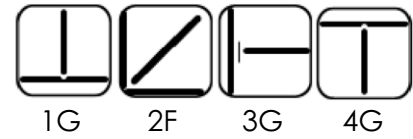
Applications

It is used for welding of high carbon steel to Mild Steel, High Carbon Steel Parts, Low Alloy Steel, Armour Plates, Cast Steels as well as unknown composition of steel.

Characteristics on Usage

It is medium coated, hydrogen controlled all position electrode. It gives a smooth clean weld deposit with least spatter due to having a special type of lime coating. The weld metal is highly resistant to cracking and gives radiographic quality. Dry the electrodes at 300 °C for hour for best result.

Welding Positions



Notes On Usage

- ⚠ Dry the electrode at 300-350 °C for 60 min. before use.
- ⚠ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.
- ⚠ Use wind screen against strong wind

LOW HYDROGEN TYPE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.35 Max	0.30 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	Hydrogen content in 100 gm weld metal
520 Min	400 Min	22 Min	40 Joules Min	5 ml (Max)

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	60 – 90
3.15 x 450	5	20		100 – 140
4.00 x 450	5	20		140 – 180
5.00 x 450	5	20		190 – 250