ROYAL – 7016 (E 7016)

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

LOW HYDROGEN TYPE ELECTRODES

Applications

For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

Characteristics on Usage

A medium heavy coated all position hydrogen controlled electrode for The welding of medium high tensile structural steel such as Carbon steels upto 0.4% C, Manganese steel upto 2.0% Mn, Silicon steel upto 0.5% Cr, Chrome Nickel steels and other heat treated steels where matching of base metal and weld metal is not necessary.

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 pupose to prevent blow hole at the arc starting.
- Keep the arc as short as possible.

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	0.30 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 (Mercury method) in 100grm weld metal
490 Min	400 Min	22 % Min	27 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 (OCV 70) /DC (+)	60-95
3.15 x 450	5	20		90-120
4.00 x 450	5	20		140-190
5.00 x 450	5	20		190-250
6.30 x 450	5	20		250-310