

# S-7016.H

TYPE : Basic

AWS A5.1 / ASME SFA5.1 E7016

JIS Z3211 E4916

EN ISO 2560-A - E42 2 B 1 2

SWAW

## Applications

S-7016.H can be used for welding of high tensile steel, such as bridges, buildings, shipbuilding, high pressure vessels and rolling stock.

## Characteristics on Usage

- Soft stable arc.
- Smooth appearance.
- No undercut formation.
- Good fluidity and removability of slag.
- Good mechanical properties.
- Excellent crack resistance and X-ray performance.

## Notes on Usage

- ① Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ② 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.
- ③ Use wind screen against strong wind.

## Welding Position



1G (PA)    2F (PB)    3G (PF)    4G (PE)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.08	0.62	1.22	0.017	0.011

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
560 (81,300)	620 (90,700)	28.5	-30 (-22)	80 (59)

## Approval

KR, ABS, LR, BV, DNV, GL, NK, MRS, CWB

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~85	90~130	130~180	180~240	250~310
V-up, OH	50~80	80~120	110~170	150~200	-