

S-7016.LS

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E7016-G H4R
JIS Z3211 E4916-N1 AP L
EN ISO 2560-A - E46 6 1Ni B 1 2 H5

Applications

S-7016.LS can be used for welding of high tensile steel for low temperature. Such as off-shore structures, LPG storage tanks, etc.

Characteristics on Usage

S-7016.LS is an extra low hydrogen type electrode for all position welding of aluminum-killed steel and TMCP steel used at low temperature.

All-weld metal is 0.9%Ni type and better notch toughness and CTOD properties at -10 °C temperature. X-ray performance and usability are good.

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 Pay attention not to exceed proper heat-input because excessive heat-input causes deterioration of impact values of all-weld metal.

Welding Position



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

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.30	0.98	0.013	0.008	0.80

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
538 (78,100)	589 (85,500)	30.0	-45 (-49)	95 (70)
			-60 (-76)	73 (54)

Approval

KR, ABS, LR, BV, DNV

Packing

Packet	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	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	80~115	110~170	150~200	-