

# S-7016.LF

Type : Basic

## Conformances

AWS A5.1/ ASME SFA5.1 E7016  
 JIS Z3211 E4916  
 EN ISO 2560-A-E42 3 B 1 2  
 KR 3H10, 3Y H10  
 ABS 3H10, 3Y  
 LR 3YH15  
 BV 3, 3YHH  
 DNV-GL 3YH10  
 NK KMW53HH

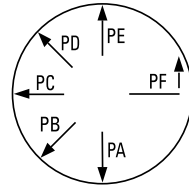
## Applications

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

## Features

- Suitable for butt and fillet welding of heavy structure
- Good crack resistance and X-ray performance
- Good mechanical properties
- Low fume

## Welding Position



## Current

AC or DC +

## Redrying Conditions

300~350°C (572~662°F) X  
 0.5~1hr

## Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

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

C	Si	Mn	P	S
0.08	0.62	1.29	0.016	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)
550 (79,900)	605 (87,800)	29.0	-30 (-22)	75 (56)

## Typical Welding Parameters / Amp.(A)

Diameter 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	80-130	110-170	150-200	-