

S-7016.M

Type : Basic

Conformances

AWS A5.1/ ASME SFA5.1 E7016

JIS Z3211 E4316

EN ISO 2560-A-E42 2 B 1 2

KR 3H10, 3YH10

ABS 3H10, 3Y

NK KMW53HH

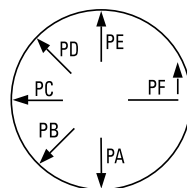
Applications

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Features

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

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	0.64	1.18	0.018	0.009

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)
539 (78,300)	617 (89,600)	26.5	-20 (-4)	73 (54)

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	90~140	140~190	190~250	250~320
V-up, OH	50~80	80~130	110~170	160~210	-

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX