

Stick electrode

- Features:**
- Good CTOD properties at temperatures down to -30°C
 - Better impact values at temperatures down to -60°C

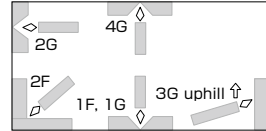
Classification: AWS A5.5 E7016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st White, 2nd Green

Polarity: AC, DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 90H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	450	5	20	97	170W, 105H, 480L
6.0	450	5	20	140	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.06	0.10
Si	0.36	0.30~0.90
Mn	1.38	1.00~1.60
P	0.01	0.03
S	<0.01	0.03
Ni	0.46	0.30~0.70
Ti	0.019	0.005~0.035
B	0.0027	0.0005~0.0045

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	150~200
6.0	250~310	-

All-weld mechanical properties

	Typical (AC)		Guaranty
	490	470	
0.2%YS (MPa)	490	470	393min.
TS (MPa)	580	570	483min.
EI on 4d (%)	29	31	25min.
IV -60°C (J)	130	120	27min.
PWHT (°Cxh)	AW	620x1	AW & 620±15x1

Approvals

ABS	3Y, 4Y400 H10
LR	5Y40m (H15)
DNV	5Y40H10, NV2-4 (L), 4-4 (L)
BV	4Y40M, H10 (KV-60)
NK	KMWL3 H10, KMW54Y40