

Applications

S-7016.G can be used for welding of high tensile steel of ships, buildings, bridges and pressure vessels.

Characteristics on Usage

It deposits weld metal of extremely good mechanical properties.

Its usability is good in all position welding and weld metal of good appearance can be obtained assuredly.

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	0.66	1.40	0.017	0.011

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)
560 (81,300)	641 (93,100)	30.4	-30 (-22)	68 (50)

Approval

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	55~90	90~130	130~180	180~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-