

## Applications

S-7016.O can be used for one side welding of pipe and general butt joints of carbon steel and high tensile steel.

## Characteristics on Usage

S-7016.O is a single coated electrode for one side welding. Its usability is extremely good in all positions.

## Notes on Usage

- ① Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ② Stop the arc after moving the crater to the side wall of the groove.
- ③ Keep the arc as short as possible.

## 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
0.07	0.45	1.10	0.015	0.007

## 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)
511 (74,200)	597 (86,700)	31.2	-30 (-22)	82 (61)

## Approval

KR, ABS, LR, DNV, NK, NAKS

## 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)
Length mm(in)	350 (14)	400 (16)	400 (16)	400 (16)
F	60~90	90~130	130~190	180~240
FV-up, OH	50~80	80~120	110~180	150~210
OSW	30~65	60~110	90~150	130~180