ROYAL - 7016 (W) (E 7016)

AWS : SFA 5.1, E 7016
IS : 814 EB 5426 H3X

Applications

It is used for welding of high carbon steel to Mild Steel, High Carbon Steel Parts, Low Alloy Steel, Armour Plates, Cast Steels as well as unknown composition of steel.

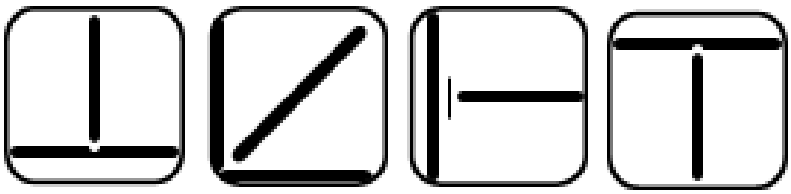
Characteristics on Usage

It is medium coated , hydrogen controlled all position electrode. It gives a smooth clean weld deposit with least spatter due to having a special type of lime coating. The weld metal is highly resistant to cracking and gives radiographic quality. Dry the electrodes at 300 °C for hour for best result.

Notes On Usage

- 1) Dry the electrode at 300-350 °C for 60 min.before use.
- 2) Adopt back step method or strike the arc on a small steel plate prepared for this particular pupose to prevent blow hole at the arc starting.
- 3) Use wind screen against strong wind

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.35 Max	0.30

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	Hydrogen content in 100 gm weld metal
520 Min	400 Min	22 Min	40 Joules Min	5 ml (Max)

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	225	900	AC / DC (+)	60 – 90
3.15 x 450	130	520		100 – 140
4.00 x 450	85	340		140 – 180
5.00 x 450	55	220		190 – 250