

# spark E7016

WELDING ELECTRODES

**A non-iron powder, basic coated low hydrogen electrode**

### Classifications:

SFA/AWS A5.1 E7016  
IS : 814 EB 5426 H3X

### Description:

Basic coated hydrogen controlled electrodes with superior metal properties and radiographic weld deposit. Hydrogen level below 5ml/100gms and impact down to -30°C.

### Special feature:

Its lower coating thickness allows greater ease of penetration in root passes for pipe welding.

### Applications:

- Welding dynamically loaded heavy structures of mild and medium tensile steels with impact down to -30°C.
- Root runs in pipelines subject to low temperature in 5G and 6G positions.
- Repair welding of high carbon and low alloy steel and steels of unknown composition (pre-heating required).
- Welding high Sulphur steels.
- Used for buffer layers for hard-facing and joining cast iron to MS (pre-heating required).

### Typical all weld metal composition %

C	Si	Mn	S	P
0.06	0.35	1.2	0.01	0.03

### Charpy V

Test temperatures (°C)	Impact values (J)
-20	110
-30	50

### Typical Mechanical Properties

U.T.S.	520MPa
Y.S.	450 MPa
% Elongation	24
Impact	27 Joules at -30°C

### Welding Parameter: Current DC+/-, AC 50V

Size (mm x mm)	Current (Amps)
3.15 x 350	100-135
4.0 x 350	135-185
5.0 x 350	170-250

