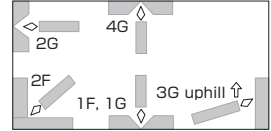


Stick electrode

Features: • Suitable for 3.5%Ni steel
Classification: AWS A5.5 E7016-C2L
Redrying Conditions: 350~400°Cx1h
Identification color: 1st Yellow green, 2nd Silver gray
Polarity: AC

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	32	170W, 120H, 380L
4.0	400	5	20	56	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.05	0.05
Si	0.36	0.50
Mn	0.73	1.25
P	<0.01	0.03
S	<0.01	0.03
Ni	3.50	3.00~3.75

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~120
4.0	130~170	110~150

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	470	440	393min.
TS (MPa)	560	530	483min.
EI on 4d (%)	31	35	25min.
IV (J)	-85°C:170	-100°C:140	-101°C: 27min.
PWHT (°C×h)	AW	605x1	AW & 605±15x1