

## Stick electrode

- Features:**
- Suitable for butt and fillet welding of heavy structures
  - Excellent mechanical properties

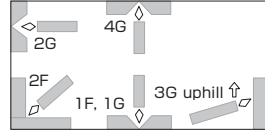
**Classification:** AWS A5.1 E7016  
EN ISO 2560-A-E 42 3 B

**Redrying Conditions:** 300~350°Cx0.5~1h

**Identification color:** 1st Blue white, 2nd White

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	20	170W, 110H, 380L
3.2	350	5	20	31	170W, 110H, 380L
4.0	400	5	20	54	170W, 110H, 430L
5.0	450	5	20	97	170W, 110H, 480L
6.0	450	5	20	137	170W, 110H, 480L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.15
<b>Si</b>	0.60	0.75
<b>Mn</b>	0.94	1.60
<b>P</b>	0.011	0.035
<b>S</b>	0.006	0.035
<b>Ni</b>	0.01	0.30
<b>Cr</b>	0.02	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	0.01	0.08
<b>Others<sup>b</sup></b>	0.98	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	150~200
6.0	210~310	-

## All-weld mechanical properties

	Typical (AC)		Guaranty	
	500	420	400min.	350min.
<b>0.2%YS (MPa)</b>	500	420	400min.	350min.
<b>TS (MPa)</b>	570	520	483min.	460min.
<b>EI on 4d (%)</b>	32	33	22min.	25min.
<b>IV -29°C (J)</b>	120	150	27min.	27min.
<b>PWHT (°C/h)</b>	AW	620x1	AW	620±15x1

## Approvals

<b>ABS</b>	3H10, 3Y, 3Y400
<b>LR</b>	3Ym H15
<b>DNV</b>	3YH10
<b>BV</b>	3H, 3YHH
<b>NK</b>	KMW53Y40H10
<b>GL</b>	3YH15
<b>CR</b>	3YH10