

OK 53.70

Type Lime-basic

SMAW
E7016-1

Description

A low-hydrogen AC/DC electrode for the one-sided welding of pipes and general structures. The root penetration is good, leaving a flat bead with easily removable slag. The stable arc and the well-balanced slag system make the electrode easy to weld in all positions. Suitable for welding transmission pipelines made from pipe steels up to API 5LX56.

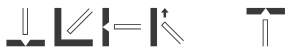
It is also suitable for welding the root in higher strength pipes, API 5LX60, 5LX65, 5LX70.

Recovery

100%

Welding current

AC, DC+(-) OCV 60 V



Classifications

SFA/AWS A5.1	E7016-1
DIN 1913	E 51 55 B10
EN 499	E 42 5 B 12 H5
GOST 9467-75	E50A
ISO 2560	E 51 5 B 24 H

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.2

Typical mech. properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	530
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
-20	150
-40	120
-50	100

Approvals

ABS	3H5, 3Y
DNV	3 YH5
LR	3YH15
Sepros	UNA 485155
VNIIST	

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	60-85	26	0.63	87.7	0.7	57
3.2	350	80-130	28	0.60	53.6	1.1	60
3.2	450	80-130					
4.0	450	115-190	24	0.63	24.6	1.7	86

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