

Covered electrode

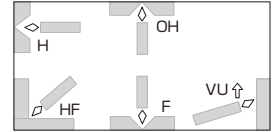
Classification: ASME / AWS A5.1 E7016
EN ISO 2560-A-E 42 2 B

Features: • Suitable for one side welding of pipes
• Extremely good arc stability in one side welding with relatively low current

Type of covering: Low hydrogen

Redrying Conditions: 300~350°Cx0.5~1h

Identification color: 1st Blue white, 2nd Pink

Welding Positions:**Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S
Example	0.08	0.64	0.86	0.012	0.008
Guaranty	0.05~0.10	≤0.75	≤1.60	≤0.020	≤0.020

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	480	560	31	-29°C: 80
Guaranty	≥400	≥480	≥22	-29°C ≥27

Recommended welding parameters

Dia.	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	60~90A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	110~170A	150~200A
Root pass	30~80A	60~110A	90~140A	130~180A

Root pass: DC-EN is also suitable.

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

ABS	LR	DNV	BV	NK	CCS
3H10, 3Y	3Ym H15	3YH10	3, 3YHH	KMW53H10	3YH10

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	20
3.2	400	5	20	35
4.0	400	5	20	53
5.0	400	5	20	82