

# ES 7016

Type Basic

SMAW

E7016

**ESWECO**  
*The Art of Welding*

## Description

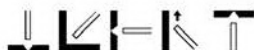
A low-hydrogen electrode with excellent running characteristics and very good mechanical properties. Because of its double coating, it creates a deep crater which stabilises the arc and gives good protection against air in inclined positions.

## Recovery

105%

## Welding current

DC + (-)



## Classifications

SFA/AWS A5.1	E7016
EN 499	E 42 4 B 22 H10
ISO 2560	E 51 5 B 24 (H)

## Typical all weld metal composition, %

C	Si	Mn
<0.1	0.5	1.0

## Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	540
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
-20	150
-40	80

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-100	24
3.2	350	80-140	26
4.0	450	110-180	24
5.0	450	180-300	26