

# ES 47.00

SMAW

E7016-1

**ESWECO**  
*The Art of Welding*

Type Lime-basic

## Description

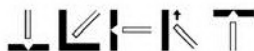
ES 47.00 is an extra-high quality LMA electrode, particularly suitable for on-site welding. ES 47.00 yields a homogeneous, high-quality weld metal with an extra low content of impurities. The electrode operates well on AC as well as DC positive and negative. DC negative is preferred, as it produces a small, easily controlled weld pool, minimising the risk of burn-through or undercutting.

## Recovery

100%

## Current

AC, DC + (-) OCV 65 V



## Classifications

SFA/AWS A5.1	E7016-1
EN 499	E 42 5 B 12 H5

## Typical all weld metal composition, %

C	Si	Mn
0.06	0.4	1.3

## Typical mech. Properties all weld metal

Yield stress, MPa	>420
Tensile strength, MPa	510-640
Elongation, %	26

## Charpy V

Test temps, °C	Impact values, J
-20	150
-40	80
-50	47

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	22
3.2	450	80-130	22
4.0	450	110-170	22
5.0	450	180-230	22