

Classifications

EN ISO 2560-A:2006	: E 38 0 B 12 H10	KS D 7004	: E4316
EN ISO 2560-B:2006	: E 43 16 A H10	JIS Z 3211	: E4316
AWS A5.1-04	: E7016		

Description

- Covering is low hydrogen type for tack welding of steels of ships, buildings and bridges.
- Good arc restriking properties.
- Designed for tack welding and intermittent welding.
- Easy slag removal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.07	0.59	0.86	0.018	0.009	0.02	0.03	0.01	0.01	0.93

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
JIS Z 3211	min. 330	min. 430	min. 20	≥ 47	≥ 27	
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 65	50	AW
Example	450	550	29			

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	4.0	5.0
Length	(mm)	350	400	400
Amp.(A)	All	90~150	140~200	190~240

Approvals

KS, JIS, CE