

S-7016.0

Type : Basic

Conformances

AWS A5.1/ ASME SFA5.1 E7016
JIS Z3211 E4316
EN ISO 2560-A E42 2 B 1 2
KR 3H10, 3YH10
ABS 3H10, 3Y
LR 3, 3YH15
DNV 3YH10
NK KMW53HH
NAKS

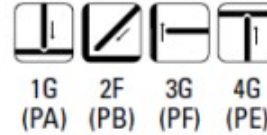
Applications

- Pipe line

Features

- Suitable for one side welding of pipe
- Stable arc
- Relatively low current

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.45	1.10	0.015	0.007

Condition	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
AW	511 (74,200)	597 (86,700)	31.2	-30 (-22)	82 (61)

Typical Operating Procedures

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	400 (16)	400 (16)
F	60-90	90-130	130-190	180-240
FV-up, OH	50-80	80-120	110-180	150-210
Root pass	30-65	60-110	90-150	130-180

Diam.	Pack/Carton	Part No.
2.5mm	5kg/ 20kg	HCS7016O25
3.2mm	5kg/ 20kg	HCS7016O32
4.0mm	5kg/ 20kg	HCS7016O40

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