

S-7016.LS

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E7016-G H4R
 JIS Z3211 E4916-N1 AP L
 EN ISO 2560-A-E46 6 1Ni B 1 2
 KR 3H10, 3YH10 (-60°C ≥34 J)
 ABS 3H10, 3Y (-60°C ≥34 J)

LR 5Y40H15
 BV 3, 3YHH (-60°C ≥34 J)
 DNV-GL 5YH10

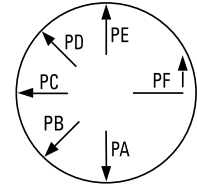
Applications

- Low temperature strength steel
- Offshore structure
- LPG, LNG storage tank

Features

- Extra low hydrogen electrode
- Good impact value at -60°C
- CTOD properties at -10°C (14°F) temperature

Welding Position



Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X
 0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	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)	✓		✓		✓		✓	

SM/AW

SAW

GM/AW

GT/AW

FC/AW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.30	0.98	0.013	0.008	0.80

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
538 (78,100)	589 (85,500)	30.0	-45 (-49) -60 (-76)	95 (70) 73 (54)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55-85	90-130	130-180	180-240	250-310
V-up, OH	50-80	80-115	110-170	150-200	-