

Classifications

EN ISO 2560-A:2006	: E 42 3 Z B 12 H10	KS D 7101	: DA5016W
EN ISO 2560-B:2006	: E 49 16-G A H10	JIS Z 3214	: DA5016W
AWS A5.5-06	: E7016-G		

Description

- Covering is low hydrogen type for welding of 490MPa class high tensile strength weathering type structural steel for vehicles, building and bridges.
- Excellent weather-proof property and crack resistance.
- Satisfactory bead appearance and 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	Cu
0.06	0.46	0.74	0.018	0.009	0.63	0.52	0.01	0.01	0.40

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	450	610	28	70	50	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F V · OH	90~130 70~110	150~190 120~160	180~230 130~170	240~280 -

Approvals

CE