

Classifications

EN ISO 2560-A:2006	: E 42 3 B 12 H5	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 16 A U H5	JIS Z 3211	: E4916 H5
AWS A5.1-04	: E7016 H4R		

Description

- Covering is low hydrogen type for welding of 490MPa class high tensile steel in ships, bridges.
- Excellent mechanical properties and radiographic soundness.
- Good impact properties and very low hydrogen content. (HD ≤4ml/100g)
- 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*	*Sum
0.07	0.57	0.87	0.013	0.011	0.02	0.03	0.01	0.01	0.94

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	500	610	27	110	90	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60~90 50~80	90~130 80~110	140~190 120~160	180~240 160~200	250~310

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH5	3YHHH	3YH5	3YH5	3YH5	3YmH5	KMW53H5

* Others : JIS, CCS, CE