

Covered Electrodes

K-7016A1

For heat-resisting steel (0.5%Mo)

Classifications

EN ISO 3580-A:2008	: E Mo B 12 H10	KS D 7022	: DT1216
EN ISO 3580-B:2008	: E 49 16-1M3 H10	JIS Z 3223	: DT1216
AWS A5.5-06	: E7016-A1		

Description

- Covering is low hydrogen type for welding of alloys used for high temperature service such as C-Mo steel pipes(STPA 12, A335-P1), boiler and heat exchanger steel tubes, rolled steel and cast steel.
- Preheat at 100~200°C and postheat treat at 620~680°C
- 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
0.07	0.54	0.83	0.015	0.009	0.02	0.03	0.52	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 390	min. 490	min. 22	≥ 47	100	PWHT
EN ISO 3580-A Example	min. 355 560	min. 510 650	min. 22 31			

* PWHT : 620°Cx1Hr

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	55~85 50~80	90~130 80~120	140~190 110~170	180~250 130~200	240~300 -

Approvals

CE