

S-7016.A1

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E7016-A1
JIS Z3223 E4916-1M3
EN 1599 - E Mo B 1 2

SWAW

Applications

S-7016.A1 can be used for welding of 0.5%Mo steel used for high temperature and high pressure boilers, chemical industries, oil refining industries and turbine casting.
Other general low alloy steel and high tensile steel.

Characteristics on Usage

S-7016.A1 is a low hydrogen type electrode. It is suitable for welding 0.5%Mo steel used at high temperature and high pressure.

Notes on Usage

- ① Preheat at 100~200°C(212~392°F) and postheat at 620~680°C(1148~1256°F).
- ② Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ③ Keep the arc as short as possible.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.07	0.50	0.80	0.012	0.008	0.60

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
560 (81,000)	650 (94,000)	28.0	620°C(1148°F)×1hr. S.R

Approval

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs)×4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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	55~90	90~130	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	-	-