

S-7016.LF

TYPE : Basic

AWS A5.1 / ASME SFA5.1 E7016
JIS Z3211 E4916
EN ISO 2560-A - E42 3 B 2

Applications

S-7016.LF can be used for welding of high tensile steel of ships, such as bridges, buildings and pressure vessels.

Characteristics on Usage

S-7016.LF is a low hydrogen type electrode. Fume generation is about 20~30% less than conventional electrode. S-7016.LF is effective for the use in insufficient ventilation.

X-ray performance and mechanical properties of all-weld metal are good.

Good crack resistance due to less hydrogen content.

Notes on Usage

- ① Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ② Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.
- 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
0.08	0.62	1.29	0.016	0.011

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)
550 (79,900)	605 (87,800)	29.0	-30 (-22)	75 (56)

Approval

KR, ABS, LR, BV, DNV, GL, NK

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	55~85	90~130	130~180	180~240	250~310
V-up, OH	50~80	80~130	110~170	150~200	-