

## Stick electrode

- Features:**
- Good CTOD properties at temperatures down to -30°C
  - Better impact values at temperatures down to -60°C

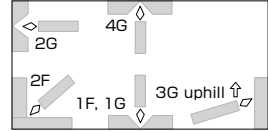
**Classification:** AWS A5.5 E7016-G

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st White, 2nd Green

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 90H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	450	5	20	97	170W, 105H, 480L
6.0	450	5	20	140	170W, 105H, 480L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.06	0.10
<b>Si</b>	0.36	0.30~0.90
<b>Mn</b>	1.38	1.00~1.60
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	0.46	0.30~0.70
<b>Ti</b>	0.019	0.005~0.035
<b>B</b>	0.0027	0.0005~0.0045

Note: <sup>a</sup>Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	150~200
6.0	250~310	-

## All-weld mechanical properties

	Typical (AC)		Guaranty
	490	470	
<b>0.2%YS (MPa)</b>	490	470	393min.
<b>TS (MPa)</b>	580	570	483min.
<b>EI on 4d (%)</b>	29	31	25min.
<b>IV -60°C (J)</b>	130	120	27min.
<b>PWHT (°Cxh)</b>	AW	620x1	AW & 620±15x1

## Approvals

<b>ABS</b>	3Y, 4Y400 H10
<b>LR</b>	5Y40m (H15)
<b>DNV</b>	5Y40H10, NV2-4 (L), 4-4 (L)
<b>BV</b>	4Y40M, H10 (KV-60)
<b>NK</b>	KMWL3 H10, KMW54Y40