ROYAL - 7016 (E 7016)

AWS : A 5.1, E 7016
IS : 814 EB 5426H3X

Applications

For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

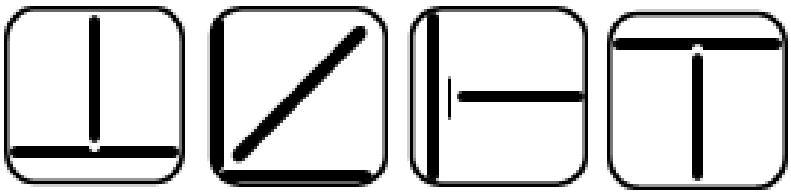
Characteristics on Usage

A medium heavy coated all position hydrogen controlled electrode for The welding of medium high tensile structural steel such as Carbon steels upto 0.4% C, Manganese steel upto 2.0% Mn, Silicon steel upto 0.5% Cr, Chrome Nickel steels and other heat treated steels where matching of base metal and weld metal is not necessary.

Notes On Usage

- 1) Dry the electrode at 300-350 °C for 60 min.before use.
- 2) Adopt back step method or strike the arc on a small steel plate prepared for this particular pupose to prevent blow hole at the arc starting.
- 3) Keep the arc as short as possible.

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)
(N/mm^2)	(N/mm^2)	(L = 5d)	AT - 30° C (J)	in 100grm weld metal
490 Min	400 Min	22 Min	27 Joules Min	5 ml (Max)

Approvals

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	225	900	AC (OCV 70) / DC (+)	60 - 95
3.15 x 450	130	520		90 - 120
4.00 x 450	85	340		140 - 190
5.00 x 450	55	220		190 - 250
6.30 x 450	30	120		250 - 310

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