


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA SPEEDARC 7016-E	
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CLASSIFICATION

ASME IIC SFA-5.1 / AWS A5.1: E7016
EN ISO 2560-A: E 38 2 B 12 H10

DESCRIPTION

- Basic electrode with exceptional weldability thanks to its double coating
- Particularly stable arc in all positions, recommended for root passes on poorly-fitting joints
- Very good deposit appearance, with concave fillet free of undercut

APPLICATIONS

Base materials

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

Examples

Unalloyed construction steels	EN 10025	S235JRG1 to S355J2G3
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10113	S275 to S420N, P275NL to P420NL
Pipe steels	EN 10208	L240NB to L415NB
	API 5LX	X42, X46, X52, X60
Shipbuilding steels	A, E, A32 - F40	

ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	P	S
0.07	0.6	1.2	<0.02	<0.02

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A ₅ [%]	CVN [J]
490	400	22	-30°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]		
550	450	27	+20°C: 150	-20°C: 80	-50°C: 50

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	3.2 x 450	4.0 x 450
Current [A]	80	115	115	150
= +	~ 70V			

Interpass temperature: ~ 250°C

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	3.2 x 450	4.0 x 450
Weight/box [kg]	5	5	6	6
Electrodes/box	~ 250	~ 152	~ 140	~ 92

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.