

ROYAL - 7016 (E 7016)AWS : A 5.1, E 7016
IS : 814 EB 5426H3X**Applications**

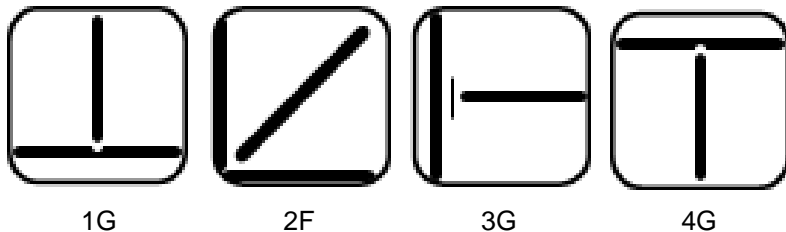
For joining Mild Steel to Cast Iron, For Butt Welding on Rail Ends & Railway Class III Steels, For fixing Rails to Mild Steel Girders for Overhead Cranes.

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 100gram 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 |